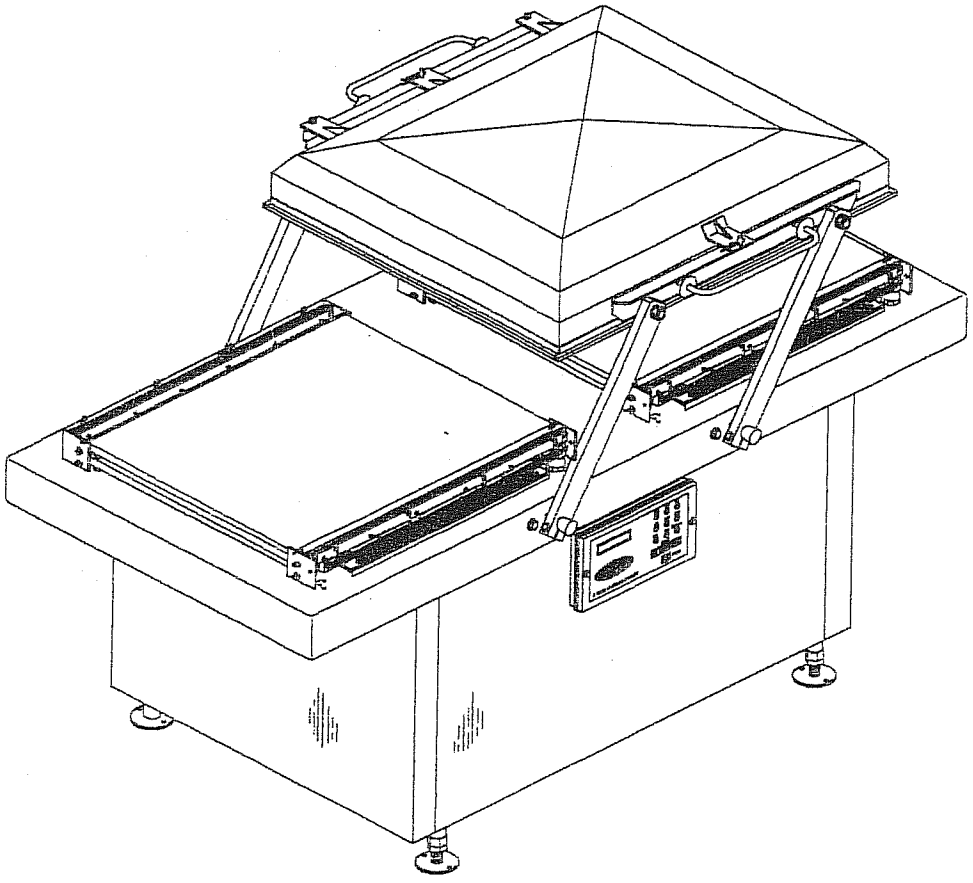
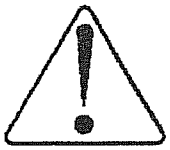
SIPROMAC

MODEL
650A



OWNERS MANUAL
(MANUEL D'UTILISATION)
(MANUAL DE UTILIZACIÓN)

Safe Operation Practices



This symbol points out important safety instructions which, if not followed, could endanger the personal safety and/or property of yourself and others. Read and follow all instructions in this manual before attempting to operate your vacuum machine. Failure to comply with these instructions may result in personal injury.

General Operation

- Read, understand, and follow all instructions in the manual and on the machine before starting. Keep this manual in a safe place for further and regular reference and for ordering replacement parts.
- Only allow responsible individuals familiar with the instructions to operate the machine. Be sure to know controls and how to stop the machine quickly.
- Never put your hands near moving parts.
- Only allow qualified individuals for the maintenance of your machine.
- Remove all obstacles, which may interfere with the machine functions.
- Clear the work area such as electrical wires, buckets, knives etc.
- Be sure that everyone else is clear of your work area before operating the machine.
- Do not sit nor stand on the machine.
- Always turn off the machine after your work is done. Never leave a running machine unattended.
- Always disconnect and wait till the machine has cooled before attempting any maintenance.
- Do not wear loose fitting clothes or jewelry as they may get caught in moving parts of the machine.
- Always wear security shoes, to prevent injury caused by moving the machine or objects falling from the machine.
- Never exceed the time limit to seal, which is recommended by the manufacturer. This is to avoid any damage that may be caused to the sealing bars and to eliminate the risk of fire in the machine. Thus avoiding corporal burns.
- Never touch the sealing bars after they have been used, this will avoid corporal burns. Wait a few minutes to let the machine cool down before touching.
- Always make sure that the sealing bars are well installed in their "Guide Blocks" before starting a cycle.
- Never incline the machine more than 30 degrees, it may tip over and hurt someone seriously.
- Work only in daylight or good artificial light.

Do not operate the machine while under the influence of alcohol or drugs!

Service

- Use proper containers when draining the oil. Do not use food or beverage containers that may mislead someone into drinking from them. Properly dispose of the containers, or store in a safe place immediately following the draining of the oil.
- Prior to disposal, determine the proper method to dispose of waste from your local office of Environmental Protection Agency. Recycling centers are established to properly dispose of materials in an environmentally safe fashion.

Do not pour oil or other fluids into the ground, down a drain or into a body of water.

Warning-Your responsibility:

This machine should only be operated by personal who can read, understand and respect warnings and instruction regarding this machine in the owners manual.

VACUUM PACKAGING MACHINE

MODEL 650A

GENERAL TABLE OF CONTENTS

VACUUM PACKAGING MACHINES

OPERATION INSTRUCTIONS

TABLE OF CONTENTS

SIPROMAC INC.

VACUUM PACKAGING MACHINES

1. SETTING UP THE MACHINE:

Before choosing the site for the machine, please consider that you will also need room for packaged and non-packaged products apart from the space needed for the machine itself.

Keep in mind that the machine must not be set up upon uneven ground. Especially with mobile models, the weight of the pump might then cause warping of the machine. Then the lid will not fit correctly.

Before starting to work, check the oil view glass on the pump, if there is a sufficient quantity of oil in the pump. Never use oil other than recommanded by the producer. Never exceed maximum quantity of oil indicated, when adding or changing oil. Verify weekly.

Due to the oil viscosity, the machine is hard to start when temperatures are very low. Therefore the pump should be put in a room with an air temperature of at least 50°F (+10°C). On the other hand, there must be free access of air to the pump to allow for cooling so that operation temperature of 160°F (70°C) is not exceeded.

2. ELECTRICAL CONNECTION:

Electrical connections must be made by qualified personnel. This person must make sure that the electrical entries corresponds to the proper voltage and amperage of the machine.

All vacuum machines are supplied with an electrical schematic drawing.

An important step in connecting the machine is to make sure that the pump turns in its correct rotation.

> Warning:The pump should not rotate more than 3 to 4 seconds in the wrong rotation or it may cause serious damage.The proper rotation is indicated by an arrow on the pump motor.

3. OPERATION:

3.1 Working principles:

A vacuum packaging cycle is made of 3 stages. First the vacuum is made, the air is completly taken out of the chamber and from bag containing the product. (See figure 1). Then it is possible to inject neutral gas from the nozzles, if the product is delicate. Finally, a mecanism pushes the sealing bar to the rubber support to seal the bag.

To obtain nice packages, the products and the bags have to be of proportional sizes. The bag's opening should never exceed 50 cm(2") past the seal bars. The product should be centered in height in relation to the seal bar by adjusting the spacers provided.

To obtain a good seal, make sure that no residue of fat is left between the bag's inner sides where sealing is done.

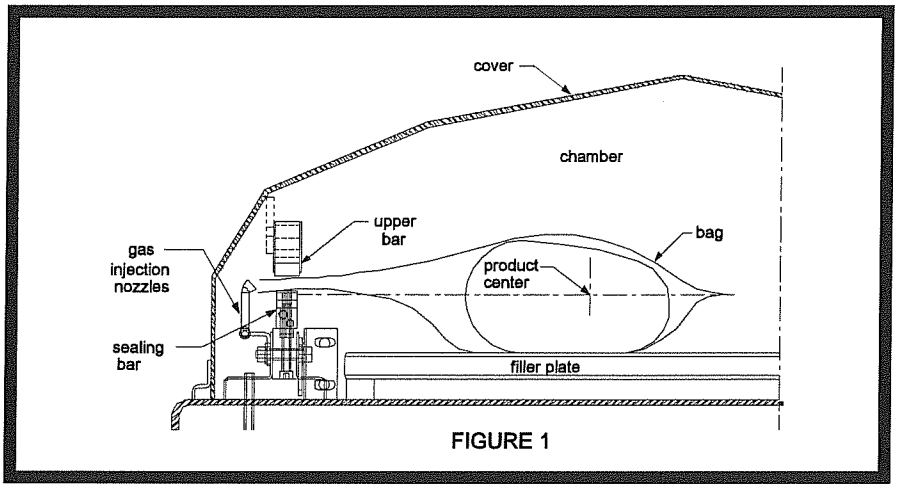


FIGURE 1

3.2 Special packaging:

3.2.1 Gas flushing (option):

There is an atmospheric pressure of 1 kg/ sq. cm(14 lbs/sq. inch) upon products when fully evacuated. Products which can be damaged by high pressure must be packaged with a partial vacuum, or the pressure must be couterbalanced by inflating the bag with gas (nitrogen or carbon dioxide) before sealing after evacuation.

For gas flushing, the bags are placed on the sealing bars, the open end placed over the gas nozzles mounted alongside the sealing bar. After evacuation, the vacuum valve closes and the gas valve opens. Gas level (%) can be set in the program menu.

The necessary gas tank and pressure valve mounted on tank is not supplied by Sipromac. The pressure of the gas regulator should be set at approximatly 1/3 kg/sq. cm (5 lbs/sq.inch.). Each machine has an adaptor for gas connection when gas flush option is ordered.

3.2.2 Top and bottom sealing (optional):

When sealing aluminium laminate bags (especially bags for e.g. coffee) it is imperative to have an upper and a lower sealing bar.

3.2.3 Electrical bag cut (optional):

This option is used to obtain a package that the excess bagtail is cut off close to the seal (cannot be used with top and bottom sealing).

3.3 Vacuum packaging operation:

Note: Refer to the menus structure on page 8 and the keyboard detail on page 9.

3.3.1 Basics:

Use key "POWER" to power ON / OFF the vacuum packaging machine. When the unit is energized, the identification of the last executed program is displayed on LCD screen.

Use the "ESC" key to change over from the programs menu to the functions menu and from the functions menu to the programs menu.

In functions menu, use key "SELECT" to select a function and key "ENTER" to accede and executed the selection.

In programs menu, use key "SELECT" to select a program and key "ENTER" to accede and modify the selection.

In programs submenu, use key "ENTER" to pass over the parameters and point to the following one; the parameters are blinking to point out the acquisition mode. A return to programs menu is performed automatically following the last parameter acquisition.

In program submenu, use key "ESC" to get back to the programs menu. Strike any key to clear the error messages which may be displayed on LCD screen.

3.3.2 Functions menu:

3.3.2.1 Create a program:

When executing the "create a program" function, the program submenu is acceded, starting with the identification. The initial identification "Pxx NO NAME" is given to the program and all parameters are established to zero; the program number is allocated automatically.

3.3.2.2 Delete a program:

When executing the "delete a program" function, the programs menu is acceded and the number of the first program in memory is blinking to point out the deletion mode. Use key "SELECT" to select a program and key "ENTER" to accede and confirm deletion of the selection. Use key "ESC" to unconfirm a deletion and to leave the function. When leaving the function, the number of the actual program on LCD screen cease to blink.

3.3.2.3 Select operating mode:

When executing the "select operating mode" function, which is available only for the automatic units, the actual selection is blinking to point out the acquisition mode. Use key "SELECT" to get through the operating modes, which are automatic, semi-automatic and manual; the validation of the selected operating mode is performed automatically. Use key "ESC" or "ENTER" to leave the function and get back to the program menu.

3.3.3 Programs menu:

3.3.3.1 Program identification:

For a selected program, set the identification, using the numeric keyboard characters chart; press numeric key untill the desired character is selected (4 times for the numeric value). Use key "ENTER" to validate the character and to validate the characters string at the end(the new characters string is blinking). In a middle of an acquisition, use key "ESC" to come backward and erase one or several characters.

Example: EXAMPLE 1 (9 characters) →
keys 2, 2, ENTER → E
keys 8, 8, 8, ENTER → X
keys 1, ENTER → A
keys 5, ENTER → M
keys 6, ENTER → P
keys 4, 4, 4, ENTER → L
keys 2, 2, ENTER → E
keys 9, 9, 9, ENTER → space
keys 1, 1, 1, 1, ENTER → 1
key ENTER to validate the characters string

3.3.3.2 Vacuum level setting:

For a selected program set the vacuum level, starting with the values; the decimal point is automatically inserted following the second digit entry and the validation is automatically performed following the third digit entry (the new vacuum level is blinking). The vacuum level is rounded off to the nearest half value. In the middle of an acquisition, use key "ENTER" to validate the vacuum level and key "ESC" to come backward and start over with a new acquisition (the old vacuum level is blinking). Set vacuum level to zero to bypass the pressure transducer and proceed only using the vacuum plus time.

Examples:
90.0% → keys 9, 0, 0 or 9, 0, ENTER or
keys 9, 0, 1 or 9, 0, 2 or 9, 0, 3 or 9, 0, 4
97.5% → keys 9, 7, 5 or
keys 9, 7, 6 or 9, 0, 7 or 9, 0, 8 or 9, 0, 9
0.0% → keys 0, 0, 0 or 0, ENTER

3.3.3.3 Vacuum plus time setting:

For a selected program set the vacuum plus time, in seconds; the validation is automatically performed following the second digit entry (the new vacuum plus time is blinking). In a middle of an acquisition, use key "ENTER" to validate the vacuum plus time and key "ESC" to come backward and start over with a new acquisition (the old vacuum plus time is blinking).

Examples:
1s → keys 0, 1 or 1, ENTER
15s → keys 1, 5

3.3.3.4 Gas flush level setting:

For a selected program set the gas flush level following the same procedure as for the vacuum level; the maximum gas flush level setting is 10% below the vacuum setting.

3.3.3.5 Sealing time setting:

For a selected program set the sealing time, starting with the seconds; the decimal point is automatically inserted following the first digit entry and the validation is automatically performed following the third digit entry (the new sealing time is blinking). The sealing time is truncated to the nearest half hundredth. In a middle of an acquisition, use key "ENTER" to validate the sealing time and key "ESC" to come backward and start over with a new acquisition (the old sealing time is blinking).

Examples:
4.50s → keys 4, 5, 0 or 4, 5, ENTER or
keys 4, 5, 1 or 4, 5, 2 or 4, 5, 3 or 4, 5, 4
2.35s → keys 2, 3, 5 or
keys 2, 3, 6 or 2, 3, 7 or 2, 3, 8 or 2, 3, 9
0.00s → keys 0, 0, 0 or 0, ENTER

3.3.4 Vacuum cycle execution:

For the manual units and the automatic units set on manual, close the cover to initiate a vacuum cycle. For the automatic units set on semi-automatic or on automatic, use push button "STOP / START" to initiate or interrupt a vacuum cycle. A selected program can be initiated only in the programs menu, when no modifications are in progress, and the access to the other programs and functions is denied. During cycle execution the operation status is sequencally displayed on LCD screen, except for the parameters established to zero, which are not displayed:

- chamber vacuum level during vacuum sequence,
- vacuum plus time status during vacuum plus sequence,
- chamber vacuum level during gas flush sequence,
- sealing time status during sealing sequence,
- chamber vacuum level during atmosphere sequence.7

During cycle execution, use key "1" to abort the vacuum sequence and execute the following sequence, which is gas flush or sealing, and key "ENTER" to accede and modify the program; the parameters become valid only for the following vacuum cycles.

3.3.5 System monitor:

To accede the diagnostics menu, power up the vacuum packaging machine while keeping pushed in the "ESC"key. Use key "SELECT" to select the system monitor function and key "ENTER" to accede and visualize the monitored parameters. Use key "SELECT" to change over from the software revision, the amount of working hours done and the amount of complete cycles performed since first initialization.

-MENUS STRUCTURE-

- Functions menu:

  "F1 CREATE A PRGM"
  "F2 DELETE A PRGM"
  "F3 SELECT OPMODE" (automatic units only)

- Programs menu:

  "Pxx NAME"

  Program submenu:

	"VACUUM: xx.x%"	(10.0% - 99.5%)
	"VACUUM PLUS: xxs"	(0s - 99s)
(units with gas option)	"GAS FLUSH: xx.x%"	(0.0% - 10% below the vacuum level)
	"SEAL TIME: x.xxs"	(0.00s - maximum unit allocated setting)
	"Pxx NAME"	(12 characters)

- Diagnostics menu (keys "ESC" & "POWER" for access):

  "DIAGNOSTICS MENU" (access code required)

  "D1 INPUTS TEST"

  "D2 OUTPUTS TEST"

  "D3 MODEL SELECT"

  "D4 GAS OPTION"

  "D5 SEALING TIME"

  "D6 COOLING TIME"

  "D7 LOADING TIME" (automatic units only)

  "D8 UNLOADNG TIME" (automatic units only)

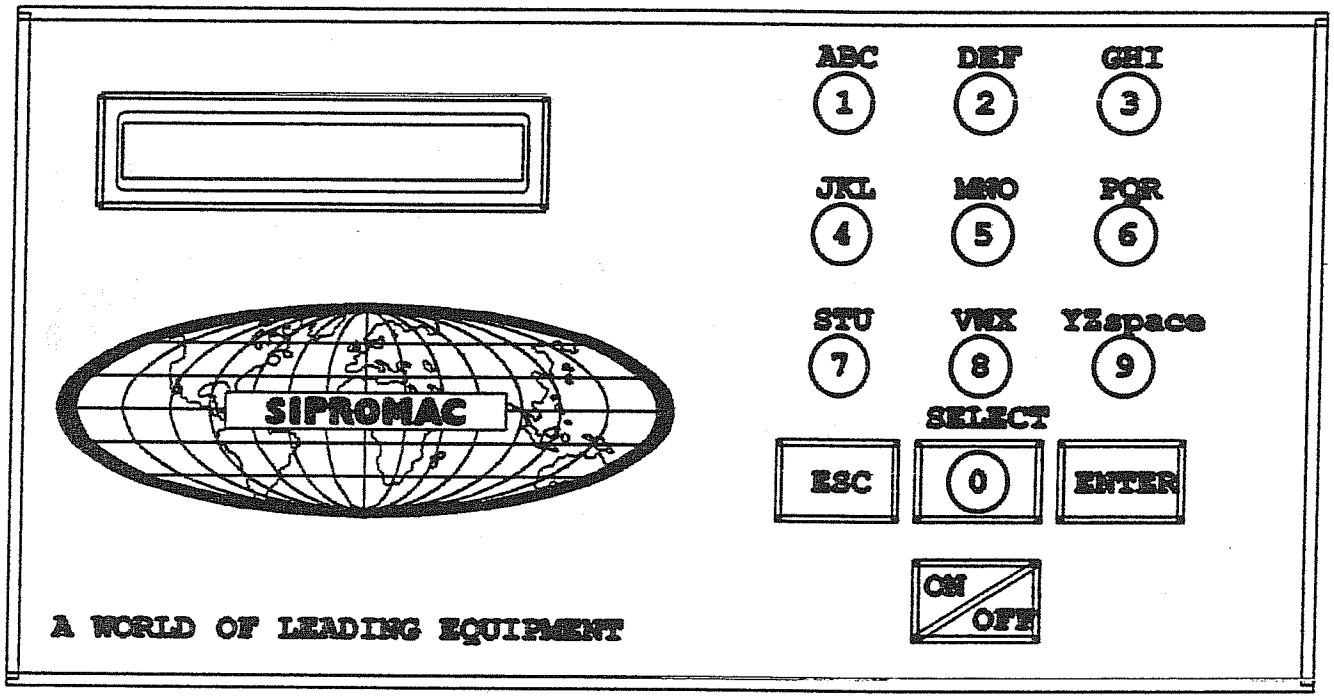
  "SYSTEM MONITOR" (no access code required)

  "SOFTWARE: R x.xx"

  "WORK HRS: xxxxx"

  "CYCLES: xxxxxxx"

-KEYBOARD DETAILS-



WARNING: ALL ELECTRICAL WORK DESCRIBED IN THIS BROCHURE SHOULD BE DONE BY A QUALIFIED AND AUTHORIZED TECHNICIAN.

3.4 Daily cleaning:

For hygenic cleanliness, it is imperative to clean chamber and spacers daily. Also clean the lid rubber to assure tight seat of the lid.

4. TROUBLE SHOOTING:

4.1 Failure during packaging cycle:

4.1.1 "VACUUM ERROR" message is displayed on LCD:

No pressure variation is picked up by the PCB transducer during the vacuum sequence within a preset period of time.

- Check vacuum lines for potential leaks or kinks.

4.1.2 "GAS FLUSH ERROR" message is displayed on LCD:

No pressure variation is picked up by the PCB transducer duringthe gas flush sequence within a preset period of time.

- Check gas flush and vacuum lines for potential leaks or kinks.

4.1.3 "ATMOSPHERE ERROR" message is displayed on LCD:

No pressure variation is picked up by the PCB transducer during the atmosphere sequence within a preset period of time.

- Check vacuum lines for potential leaks or kinks.

4.1.4 "COVER DOWN ERROR" message is displayed on LCD(manual units):

The input signal of the down position switch has been lost during cycle execution.

- Check limit switch adjustment.

4.2 Insufficient vacuum:

4.2.1 Leakage in the bag:

Most frequently, insufficient vacuum in bags is due to leakage in bag and not due to any fault of the machine.

Pin-hole leak for which there is no obvious explanation is due to faulty bag material.

Pin-hole leak caused by sharp edge of the product (bone, etc.).Use bone-guard or thicker film.

Tear in bag by careless handling (sharp edge on filling table, damage made by retailer or customer).

Leakage in lateral or bottom seal, complain to supplier of bags or film.

4.2.2 No leakage in the bag:

Bag is too large, therefore the surplus of air remains visible (there is surplus of air in.... 0.4% of the bag volume in each bag). Use bags of suitable size.

Evacuation time is too short:

Pressure bar is jammed and closes opening of bag during evacuation.

4.2.3 Insufficient vacuum in chamber:

If troubles described under 4.2.1 and 4.2.2 do not apply, there is something wrong with the evacuation.To find the leakage quickly, check for leaks with a precision vacuumeter, going back step by step from the chamber to the pump.

At the chamber (measuring point at base of valve) at maximum time of evacuation. If more than 6 torr, proceed directly to the pump, if more than 3 torr:have pump service by pump supplier.If pressure at pump is good, reconnect hoses to pump and measure again.

Verify at vacuum hose connections and valve connections.

When proceeding this way, starting from pump, loss of pressure per step must not exceed 0.5 to 1 torr.

Warning:Verify connections of measuring equipment before verifing machine.

Most frequent points of leakage: lid gasket, damaged vacuum hose or loose hose clamps.

4.3 Faulty seal:

4.3.1 Insufficient seal:

Damaged teflon or silicone rubber.

Sealing pressure too low, bellows leaking or pressure bar jammed.

Leakers in seal: heating wire mechanically damaged (knicked) or silicone rubber uneven.

4.3.2 No seal:

Sealing wire burnt.

Faulty contact in sealing circuit.

Sealing transformer burnt through.

Contactor does not work.

4.3.3 Permanent sealing current:

Contactor is jammed check sealing transformer for damage through overload.

4.3.4 Seal does not stick:

Insufficient layer of polyethylene (inferior quality of bags).

Seal area extremely contaminated by fat or meat juice. Use filling aid.

Sealing temperature is too low (when using very thick films).

Warning: Do not increase sealing time more than really necessary; higher temperature will reduce working life of teflon and silicone rubber.

4.4 Fault in the valve:

Vacuum or air valve does not open.

Check whether there is voltage on the magnetic valves during their period of operation. If there is no voltage a wire is broken or the PC board is damaged.

Lid does not open at the end of the cycle; air enters, but there is still 20 - 40% vacuum in chamber. Vacuum valve does not close.

4.5 MC40 Control board failure

NOTE:Refer to menu structure on page 8.

This board software is allowing access to a "Diagnostics Menu". Only qualified service technicians are authorized to access this menu by entering a security password.

By acceding either the "D1 input test" feature or the "D2 output test" feature,a trained technician will be able to quickly know the origin of the problem:pump, sealing system,pneumatic problem,security switches problem,etc...

Keep in mind that in most cases trouble is due to a leakage, loose electrical connection or evident dammage to the main component:vacuum pump, valves..., electrical contactors, thermal overload, fuses holder or transformer.

For assistance do not hesitate to contact your local service technicians.

5. Regular maintenance:

Routine controls to be made at regular intervals:

Check teflon for wear.

Check silicone rubber for burnt spots and smooth even position.

Check pressure bar for jamming.

Check lid sealing for damage and hardened spots.

Check switch-point of micro switch, adjust if necessary.

Check evacuation hose for damage (contraction of diameter, or abrasions).

Check vacuum connections for tightness.

Check oil in pump (oil level in view glass; add if necessary. Regular change of oil - necessity indicated by change of color).

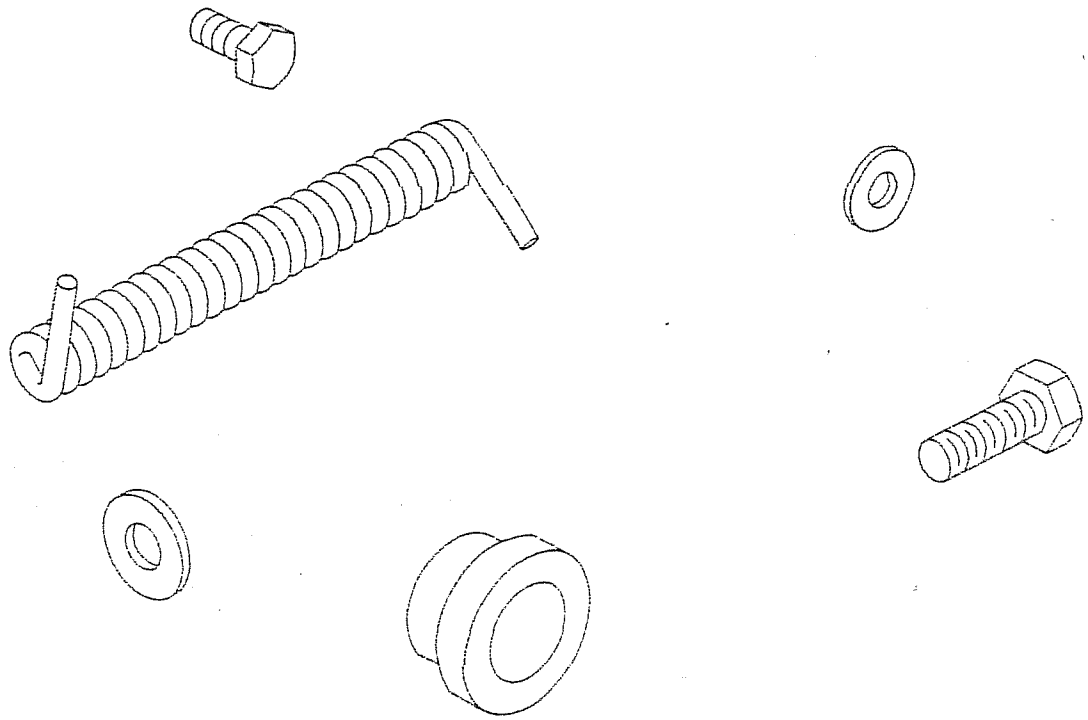
Check vacuum in chamber with precision vacuumeter.

Check function of cycle with various settings of timers.

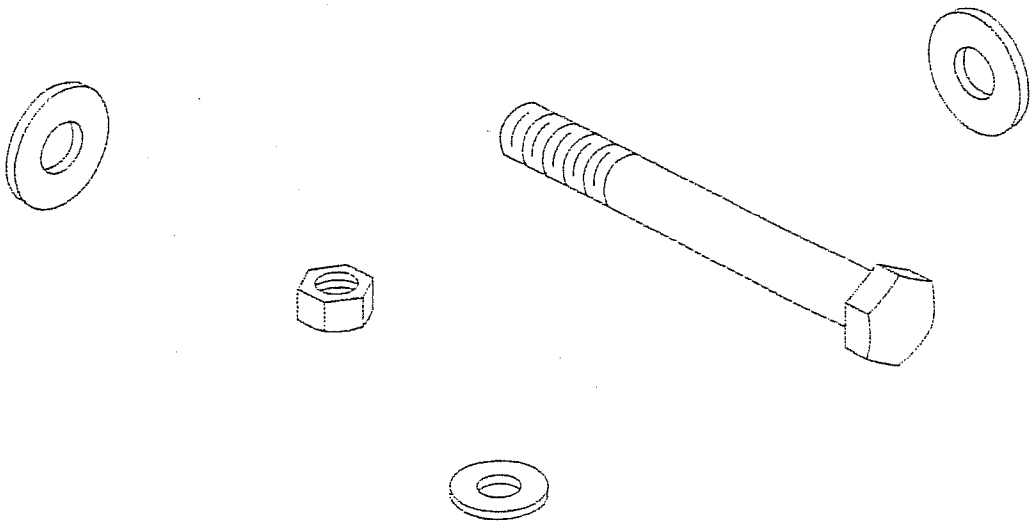
INSTALLATION NOTICE FOR MODELS:
420A,450T,450A,550A,600A,620A, 650A AND 700A

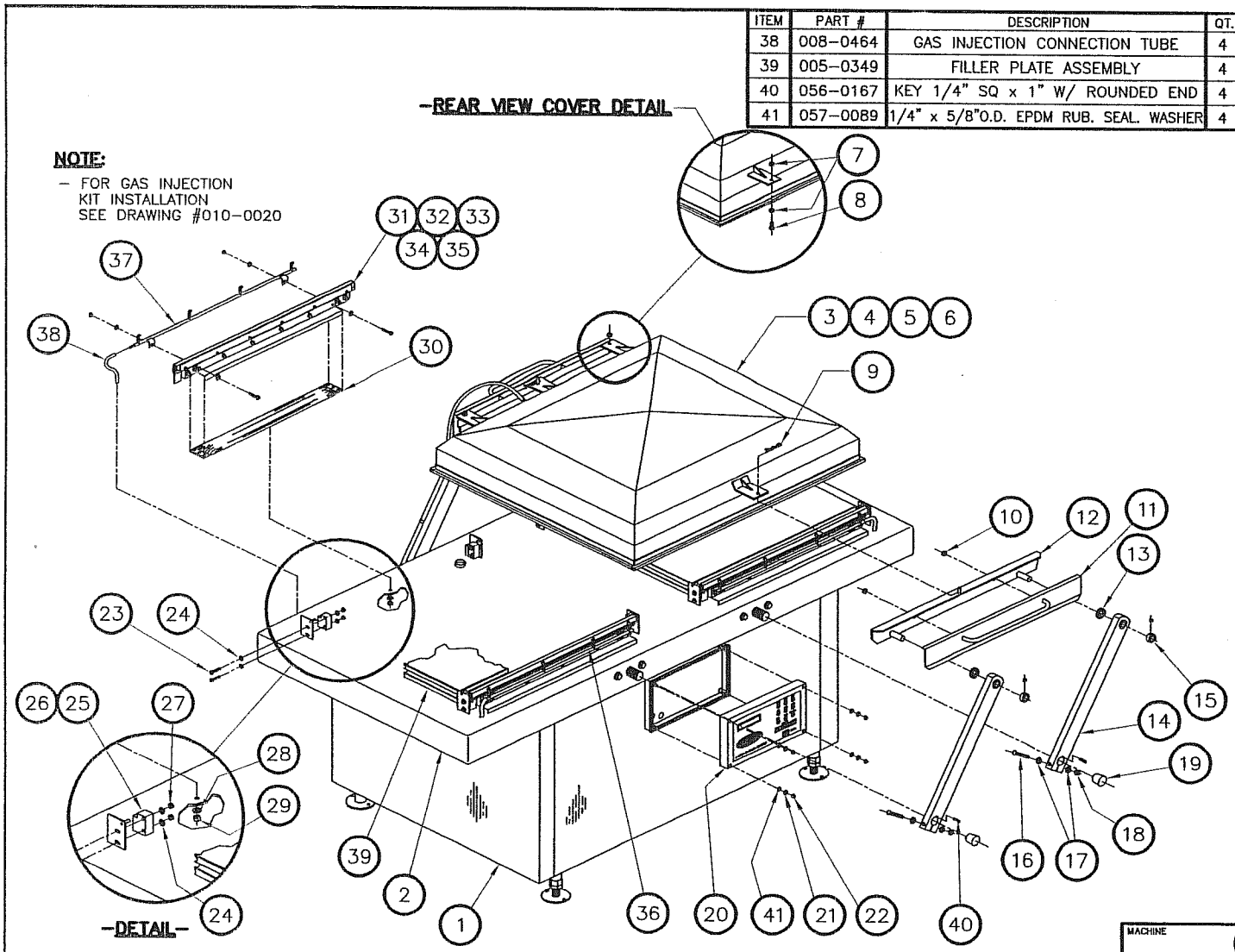
IN ORDER TO RESPECT NSF REGULATIONS:

NOTE: A PLASTIC CAP IS INSTALLED ON THE TABLE TOP VACUUM INLET USED FOR LEANING PURPOSES ONLY AND IS TO BE REMOVED PRIOR TO OPERATING THE MACHINE.



MECHANICAL DRAWING





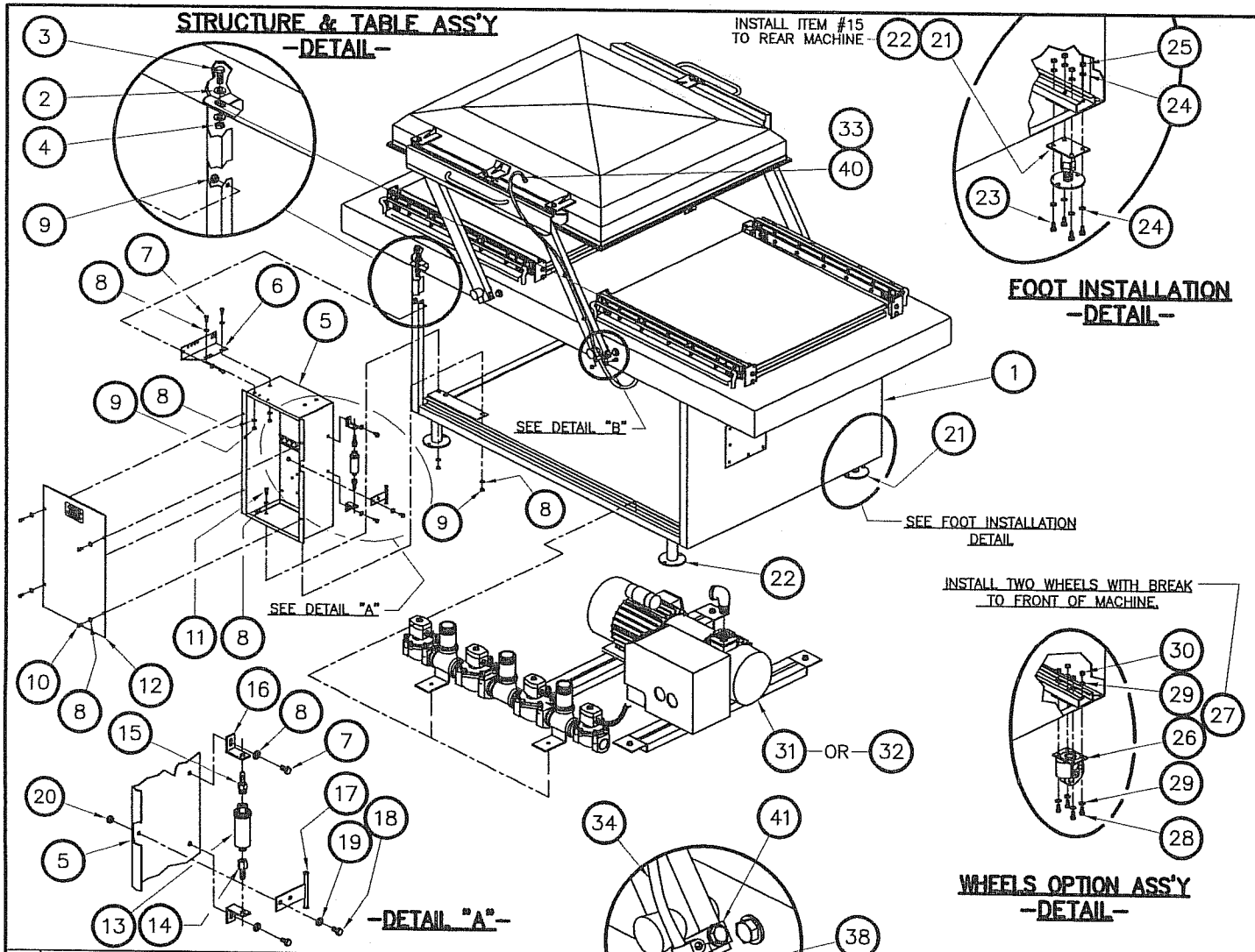
ITEM	PART #	DESCRIPTION	QT.
38	008-0464	GAS INJECTION CONNECTION TUBE	4
39	005-0349	FILLER PLATE ASSEMBLY	4
40	056-0167	KEY 1/4" SQ x 1" W/ ROUNDED END	4
41	057-0089	1/4" x 5/8"O.D. EPDM RUB. SEAL. WASHER	4

ITEM	PART #	DESCRIPTION	QT.
1	005A0465	BODY ASSEMBLY	1
2	004B0137	CENTRAL SHAFT ASSEMBLY	1
3	005-0469	8" COVER ASSEMBLY (OPT.)	1
4	005-0470	12" COVER ASSEMBLY	1
5	005-0477	8" COVER ASS'Y (M.B.C. OR M.B.C.T.B.S) (OPT.)	1
6	005-0478	12" COVER ASS'Y (M.B.C. OR M.B.C.T.B.S) (OPT.)	1
7	051-0600	HEX. NUT 5/16"-18 NC. S/S	4
8	051-0305	HEX. BOLT 5/16"-18 NC. X 1" S/S	2
9	056-0125	HITCH PIN CLIP	2
10	051-0630	HEX. NUT 1/2"-13 NC. S/S	4
11	004-0213	COVER HANDLE ASSEMBLY	2
12	005-0359	ARM SUPPORT	2
13	008-0368	SPACER	4
14	004A0383	COVER ARM ASSEMBLY	4
15	105-0430	COLLARS W/ 5/16"-18 NC. SET SCREW	4
16	051-0422	HEX. BOLT 3/8"-16 NC. X 3 1/4" S/S	4
17	051-0783	FLAT WASHER (THICK) 3/8" S/S	8
18	051-0622	HEX. NUT 3/8"-16 NC. NYLON LOCK S/S	4
19	057-0013	SHAFT END CAP	4
20	005A0583	P.C. BOARD SUPPORT ASSEMBLY	1
21	051-0740	FLAT WASHER 1/4" S/S	4
22	051-0591	ACORN NUT 1/4"-20 NC. S/S	4
23	051-0250	HEX. BOLT 1/4"-20 NC. X 1 1/2" S/S	16
24	051-0740	FLAT WASHER 1/4" S/S	32
25	002-0326	LEFT/ SEAL BAR GUIDE BLOCK	4
26	002-0327	RIGHT/ SEAL BAR GUIDE BLOCK	4
27	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	16
28	051-0780	FLAT WASHER 3/8" S/S	4
29	051-0620	HEX. NUT 3/8"-16 NC. S/S	4
30	005-0651	BELLOWS ASSEMBLY	4
31	005A0547	SEAL BAR ASS'Y W/ SUPPORT	4
32	005A0548	SEAL BAR ASS'Y W/ SUPPORT (BAG CUT OPT.)	4
33	005A0549	SEAL BAR ASS'Y W/ SUPPORT (TOP & BOTTOM OPT.)	4
34	005A0550	SEAL BAR ASS'Y W/ SUPPORT (M.B.C.) (OPT.)	4
35	005A0551	SEAL BAR ASS'Y W/ SUPPORT (M.B.C.T.B.S) (OPT.)	4
36	005A0814	GAS INJECTION BAR ASS'Y (OPT.)	2
37	005A0350	GAS INJECTION BAR ASS'Y (OPT.)	2

LET.	MODIFICATION	DATE	INT.
L	REDRAWN	05-09-07	M.A.L.

MACHINE: 650A
PART: MACHINE ASSEMBLY FRONT VIEW
METRIC TOLERANCE: D. ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°
INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM:
CNC:
DEPT: M-I
QT. 1
MAT:
DWG BY M.A.LEBLANC DATE 05-09-07
APP. DATE 25-11-08
NO. 005B0352

005B0352



ITEM	PART #	DESCRIPTION	QT.
1	005A0352	MACHINE ASSEMBLY FRONT VIEW	1
2	051-0783	FLAT WASHER 3/8" (THICK) S/S	12
3	051-0360	HEX. BOLT 3/8"-16 NC. X 1" S/S	6
4	051-0620	HEX. NUT 3/8"-16 NC.	6
5	005-0374	ELECTRICAL BOX PRE-ASSEMBLY	1
6	001-1364	LEFT/ ELECTRICAL BOX UPPER SUPPORT	1
7	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	4
8	051-0740	FLAT WASHER 1/4" S/S	12
9	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	3
10	052-0402	HEX. BOLT 1/4"-20 X 1/2" BRASS	4
11	051-0190	HEX. BOLT 1/4"-20 NC. X 3/4" S/S	2
12	004-0279	E-BOX COVER ASS'Y	1
13	114-2020	DRYER FILTER	1
14	101-0210	STRAIGHT 1/4" FNPT X 1/4" HOSE	1
15	101-0200	STRAIGHT 1/4" MNPT X 1/4" HOSE	1
16	001-2062	DRYER SUPPORT	2
17	005-0323	GAS INLET ASSEMBLY (OPTION)	1
18	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S (OPTION)	1
19	051-0740	FLAT WASHER 1/4" S/S (OPTION)	1
20	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S (OPTION)	1
21	005-0361	FRONT LEGS ASSEMBLY	2
22	005-0362	REAR LEGS ASSEMBLY	2
23	051-0300	HEX. BOLT 5/16"-18 NC. X 3/4" S/S	16
24	051-0760	FLAT WASHER 5/16" S/S	32
25	051-0600	HEX. NUT 5/16"-18 NC. S/S	16
26	130-5HPB	WHEEL W/ BRAKES (OPT.)	2
27	130-5PH0	WHEEL W/ 0 BRAKES (OPT.)	2
28	052-0520	HEX. BOLT 5/16"-18 NC. X 3/4" ZINC (OPT.)	16
29	052-2150	FLAT WASHER 5/16" ZINC (OPT.)	32
30	052-3110	HEX. NUT 5/16"-18 NC. ZINC (OPT.)	16
31	004A1472	PUMP "BUSCH" 165M3 ASS'Y	1
32	004A1473	PUMP "BUSCH" 255M3 ASS'Y	1
33	101-0200	STRAIGHT 1/4"MNPTx1/4"HOSE BARB	1
34	104-00633	SILICONE TUBING 1/2" OD X 1/4" ID 70 DURO (5 FT)	1
35	105-0450	METAL CABLE CLAMPS #6 SS	3
36	058-0025	NYLON SPACER .257ID x.5000D x"	3
37	051-0233	SCREW 1/4-20x 1 1/4" PAN PHIL SS	2
38	051-0212	SCREW 1/4-20x 1" PAN PHIL SS	1
39	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	1
40	105-0220	1 EAR CLAMPS 1/2" SS	1
41	001-1876	LOWER WIRE SUPPORT	1

LET.	MODIFICATION	DATE	INT.
R	MODIFIED VIEW ITEM #1	04-12-15	M.A.L.
Q	ADDED PARTS #33 TO #41	04-11-09	M.A.L.
P	MODIF # A-0382	04-02-27	B.C.
N	005-0374 ÉTAIT 005-0623	04-01-06	J.G.
M	MODIF. #A-0337	02-11-12	Y.C.
L	REDRAWN	00-03-22	S.L.

NOTE:
- FOR GAS INJECTION INSTALLATION SEE #010-0020

MACHINE: 650A	METRIC TOLERANCE: 0. ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°	INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: MACHINE ASSEMBLY REAR VIEW	N.T.S.		
ITEM:	CNC:	SCALE	QT. 1
MAT:	DWG BY: SYLVAIN L. DATE 00-03-22		NO. 005A0353
	APP. DATE 04-12-16		

005A0353

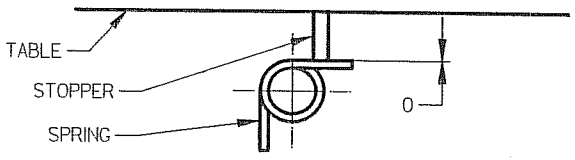
004B0137

SPRING ADJUSTMENT PROCEDURE

A - PLACE COVER UP (ARMS VERTICAL) TO FREE TENSION OF SPRINGS.

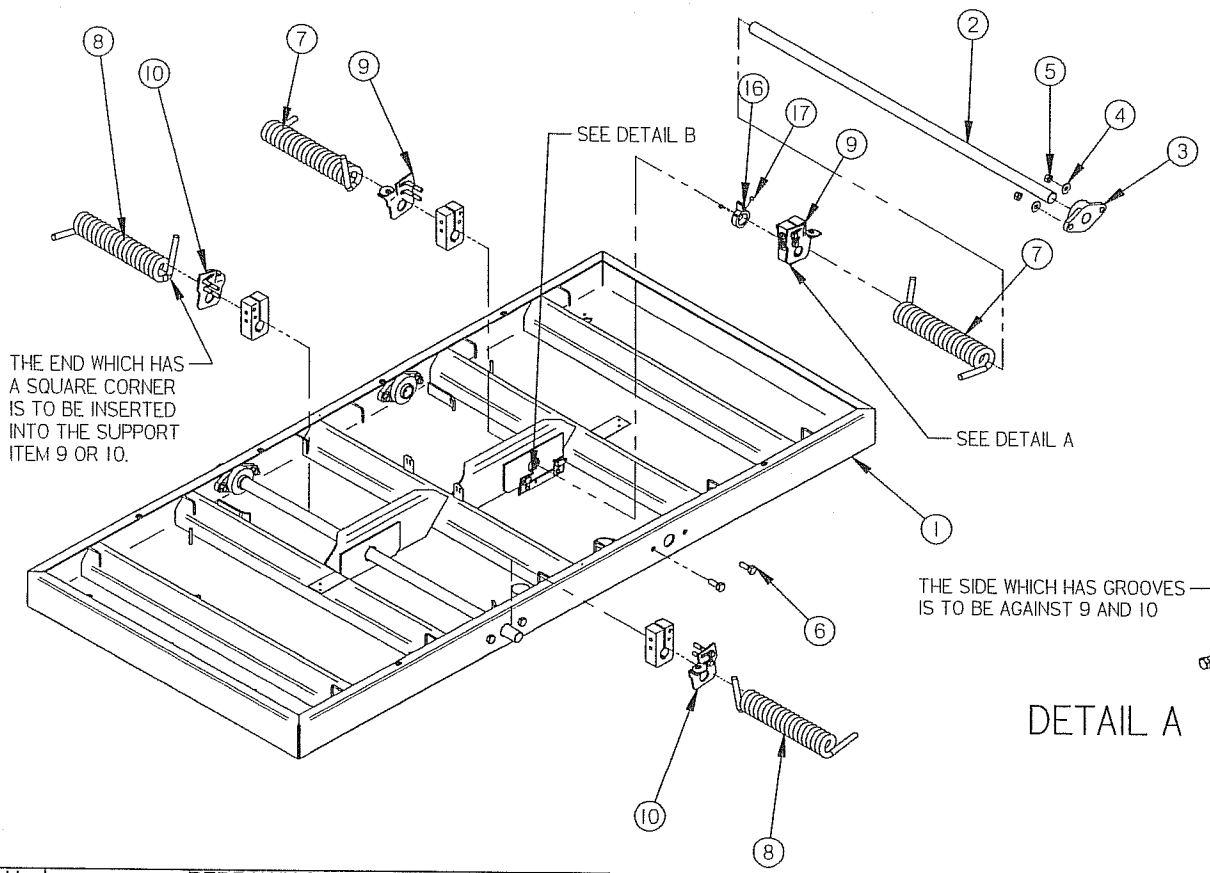
B - LOOSEN BOLTS ITEM #14 ON THE LEFT & RIGHT SPRING SUPPORT PLATE ASS'Y ITEM #9 & #10

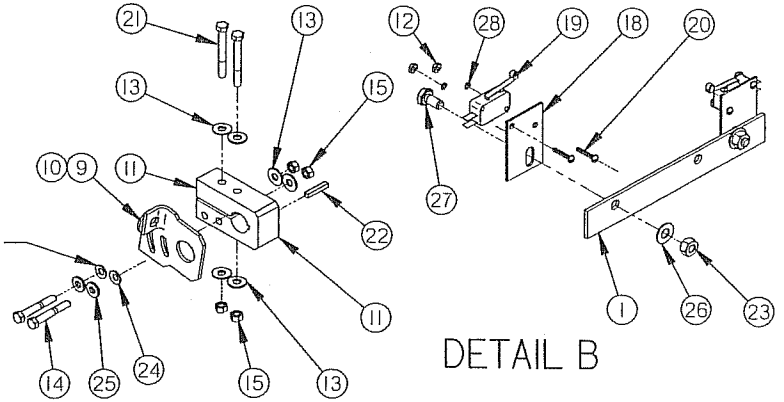
C - TURN SPRING/BLOCK ASSEMBLY TO OBTAIN 0mm AS SHOWN BELOW.



D - RETIGHTEN BOLTS ITEM #10 ON LEFT & RIGHT SPRING SUPPORT PLATE ASS'Y

ITEM	PART #	DESCRIPTION	QT.
1	005A0355	TABLE ASSEMBLY	1
2	009A0056	CENTRAL SHAFT	2
3	075-1650	FLANGED BEARING W/ GREASE FITING 90°	4
4	051-0790	WASHER 1/2" FLAT S/S	8
5	051-0630	NUT 1/2"-13 S/S	8
6	051-0441	BOLT 1/2"-13 x 1 1/2" SS	8
7	008-0589	RIGHT COVER SPRING	2
8	008-0590	LEFT COVER SPRING	2
9	004A0222	LEFT SPRING SUPPORT ASS'Y	2
10	004A0170	RIGHT SPRING SUPPORT ASS'Y	2
11	002A0319	SPRING BLOCK	4
12	051-0540	NUT #4-40 HEX S/S	4
13	052-2060	FLAT WASHER 3/8" ZINC	24
14	052-0775	BOLT 3/8"-24x2-1/2" ZINC	8
15	052-3128	NUT 3/8"-24 UNF ZINC	16
16	005-0154	MICRO-SWITCH COLLAR ASS'Y	1
17	051-0334	SCREW 3/8"-16 x 3/8" SET HEX SKT	2
18	001-1294	MICRO-SWITCH FIXATION PLATE	2
19	026-0610	LIMIT SWITCH LONG ROLLER	2
20	051-0080	SCREW 4-40 x 5/8" RND SLOT SS	4
21	052-0777	BOLT 3/8"-24 x 3" ZINC	8
22	056-0168	KEY 1/4" SQ. x 1-1/2"	4
23	051-0580	NUT ¼"-20nc. S/S	2
24	052-2071	WASHER 3/8" CONTACT BELLVILLE STL.	8
25	051-0783	WASHER 3/8" FLAT THICK S/S	8
26	051-0740	WASHER 1/4" FLAT S/S	2
27	051-0180	BOLT. HEX. 1/4"-20 NC. x 1/2" S/S	2
28	051-0715	WASHER #4 LOCK SS	4



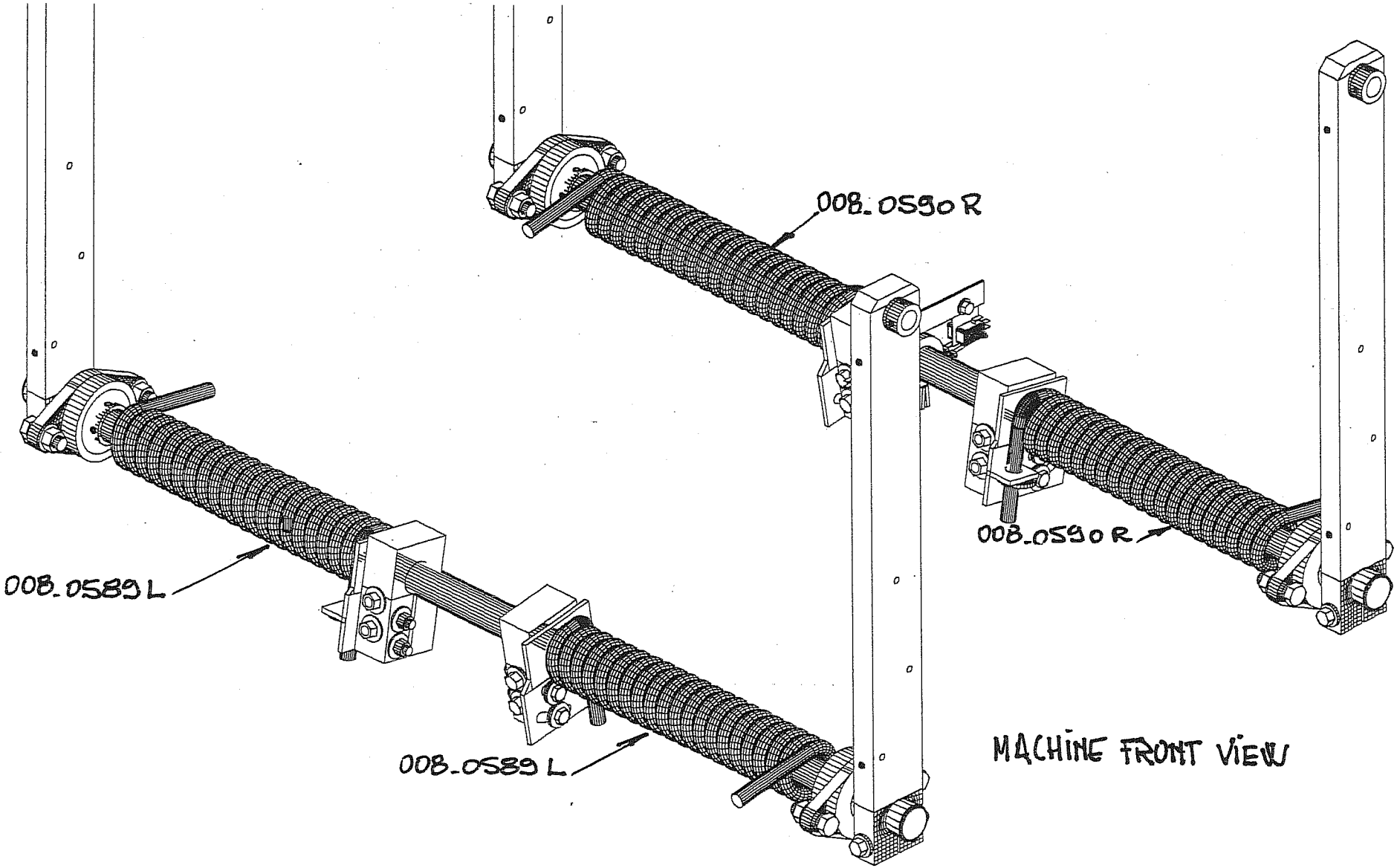


DETAIL A

DETAIL B

H	REDRAWN S.E.	05-05-12	M.A.
LET.	MODIFICATION	DATE	INT.

MACHINE: 650A	DEPT. TOL.	METRIC	INCH	SIPROMAC	
	USINAGE	± 0.1	± 0.004"	ST-GERMAIN DE GRANTHAM	
	TOLERIE	± 0.5	± 0.020"	QUEBEC CANADA	
	SOUDAGE	± 0.5	± 0.020"		
PART: CENTRAL SHAFT ASSEMBLY			N.T.S.		
ITEM	CNC			DEPT. M-I	QTY. 1
MAT.	DWG BY M.A.L.	DATE 05-05-12		NO. 004B0137	
	APP. BY	DATE 05-07-28			



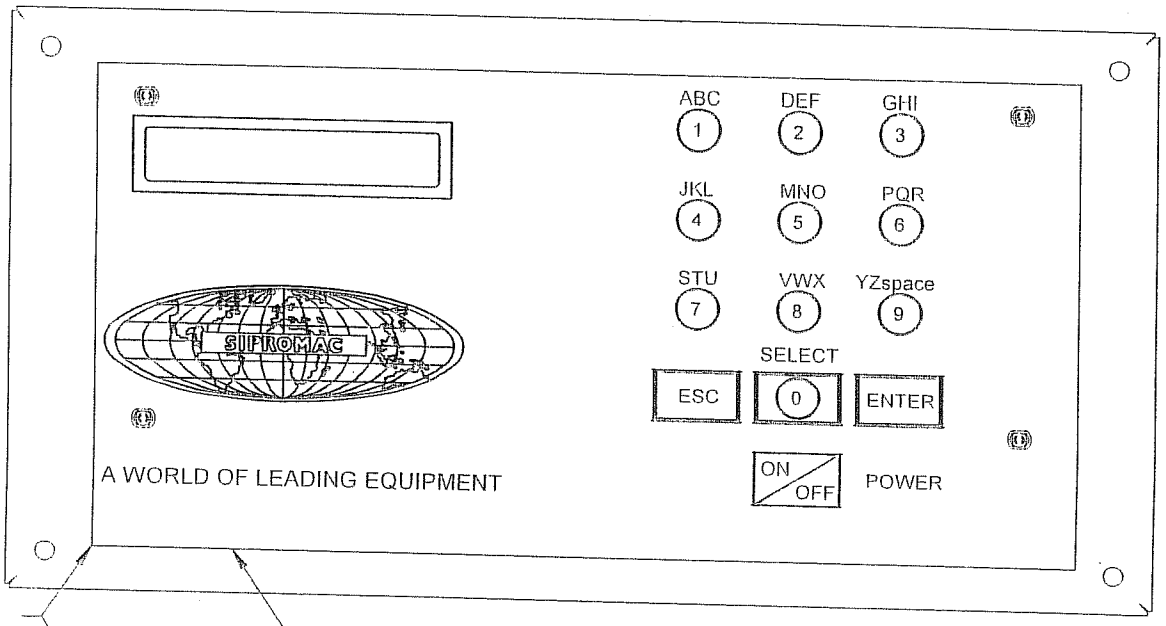
MACHINE FRONT VIEW

650_680_700 A

CENTRAL SHAFT ASSEMBLY

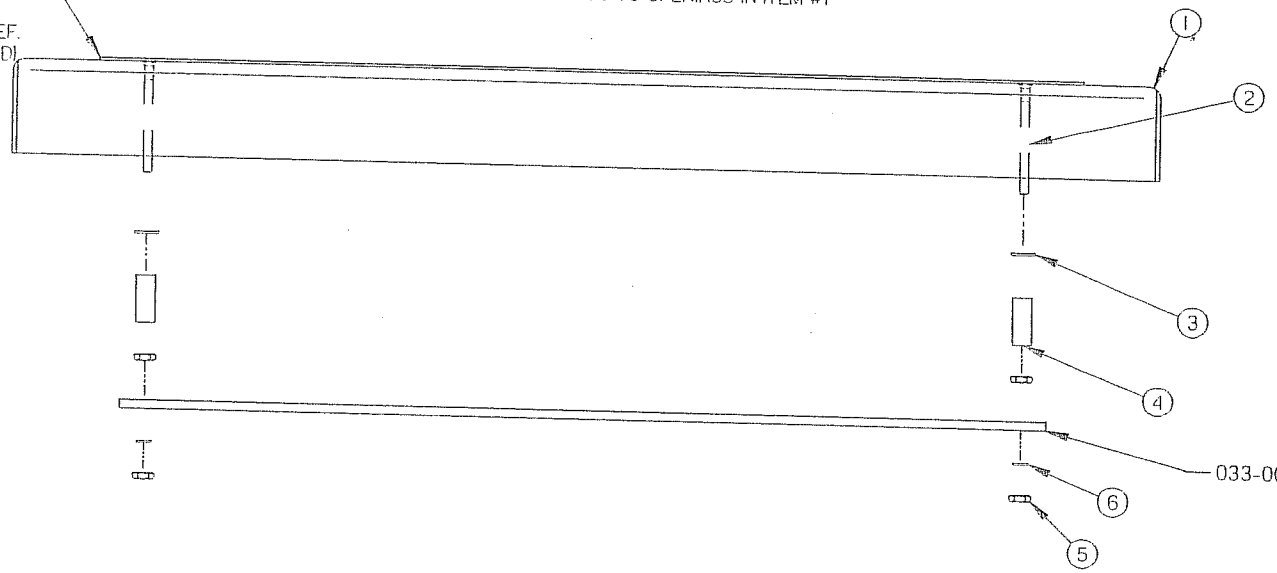
005A0583

ITEM	PART #	DESCRIPTION	QT.
1	004A0425	FRONT MC-40 SUPPORT PRE-ASS'Y	1
2	051-0092	SCREW #4-40 x 1 1/4" FLAT SLT S/S	4
3	051-0713	WASHER #4 FLAT S/S	4
4	058-0120	CPVC SPACER 0.120" x 1/4" x 5/8"	4
5	051-0540	NUT #4-40 HEX S/S	4
6	051-0715	WASHER #4 LOCK SS	8



033-0015 OR
033-0017 OR
033-0018 OR
KEY BOARD REF.
(NOT INCLUDED)

USE JIG TO INSTALL, IN REGARDS TO OPENINGS IN ITEM #1



033-0038 P.C. BOARD REF. (NOT INCLIDED)

LET.			
G	REDRAWN	05-09-01	M.A.
	MODIFICATION	DATE	INT.

MACHINE: 420A, 450A, 450T, 500A, 550A, 600A, 580A, 620A & 650A

PART: FRONT MC-40 SUPPORT ASS'Y

ITEM

MAT.

CNC

DEPT. TOL.	METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

DWG BY M.A.L. DATE 05-09-01

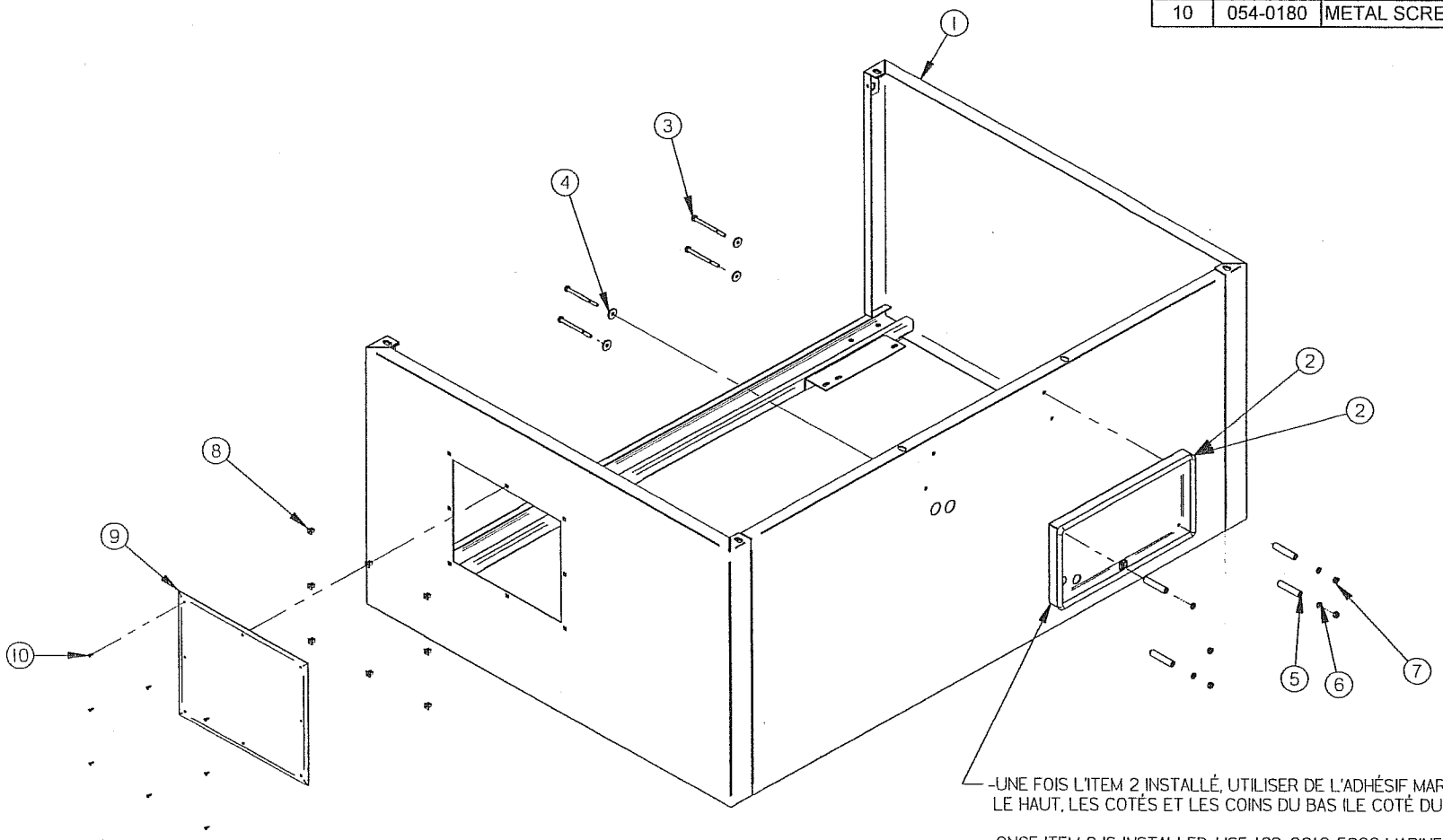
APP. BY DATE 05-10-24

DEPT. M QTY. 1

NO 005A0583

005A0465

ITEM	PART #	DESCRIPTION	QT.
1	004A0138	STRUCTURE PRE-ASSY	1
2	005A0584	REAR MC-40 SUPPORT ASS'Y	1
3	051-0287	BOLT 1/4-20 x 3-1/4" S/S	4
4	051-0757	WASHER 1/4" FLAT THICK S/S	4
5	058-0140	PLASTIC SPACER 0.266" x 1/2" x 2 1/4"	4
6	051-0750	WASHER 1/4" LOCK S/S	4
7	051-0580	NUT ¼"-20nc. S/S	4
8	057-5010	NYLON SCREW #10 RECEPTACLE INSERT	8
9	001A3230	STRUCTURE COVER	1
10	054-0180	METAL SCREW #6 x 3/8" PAN SLOT S/S	8



-UNE FOIS L'ITEM 2 INSTALLÉ, UTILISER DE L'ADHÉSIF MARIN 5200 #169-0210 POUR SCELLER LE HAUT, LES COTÉS ET LES COINS DU BAS (LE COTÉ DU DESSOUS N'EST PAS SCELLÉ)

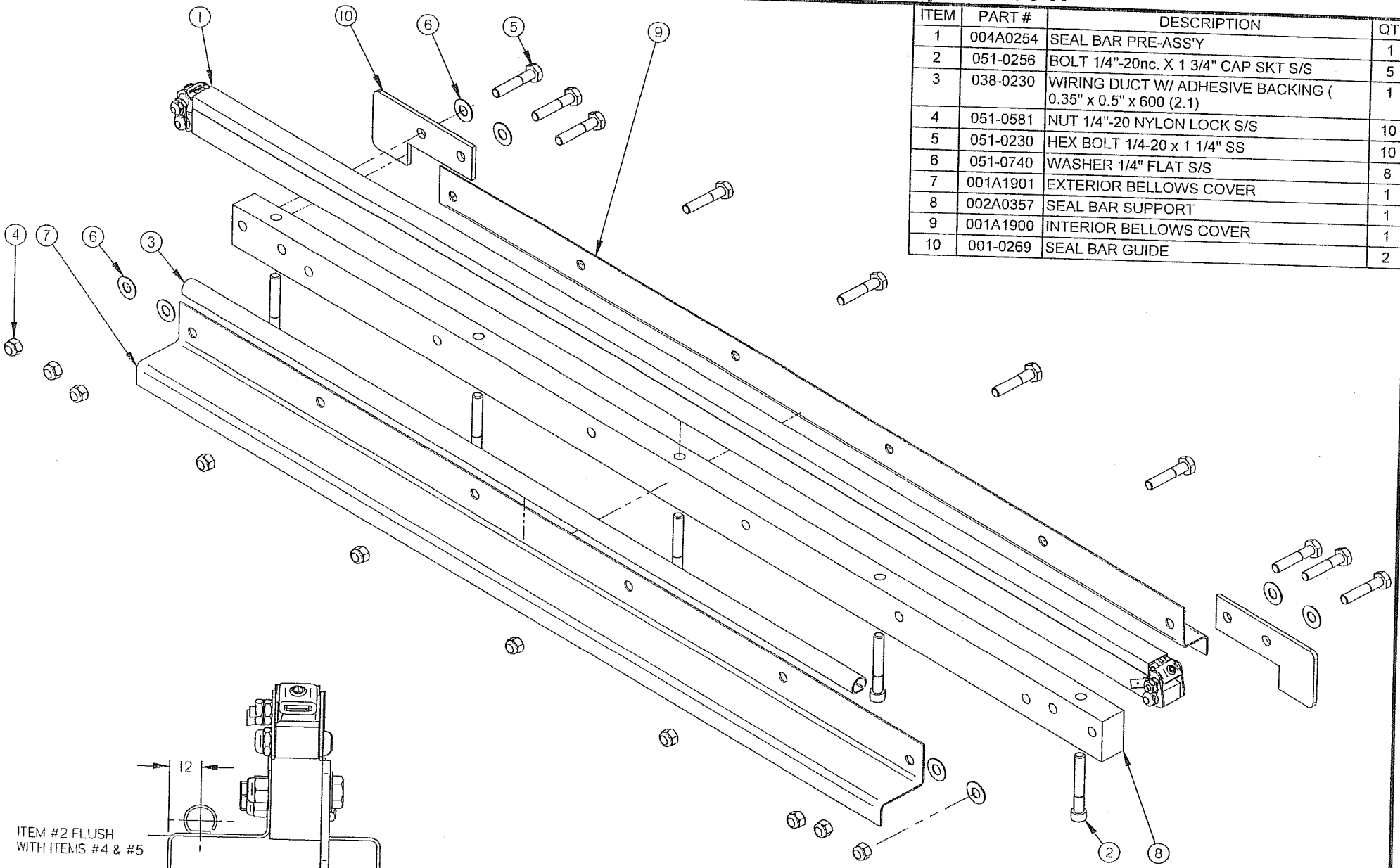
-ONCE ITEM 2 IS INSTALLED, USE 169-0210 5200 MARINE ADHESIVE TO SEAL TOP, SIDES & BOTTOM CORNERS (UNDER SIDE NOT SEALED).

LET.	MODIFICATION	DATE	INT.
B	REDRAWN	05-09-07	M.A.

MACHINE: 650A	DEPT. TOL / METRIC / INCH: USINAGE ± 0.1 ± 0.004"; TOLERIE ± 0.5 ± 0.020"; SOUDAGE ± 0.5 ± 0.020"	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA	
PART: STRUCTURE ASSEMBLY	N.T.S.		
ITEM	CNC	DEPT. M	QTY. 1
MAT.	DWG BY M.A.L. DATE 05-09-07	NO. 005A0465	
	APP. BY DATE 05-11-07		

005B0547

ITEM	PART #	DESCRIPTION	QT.
1	004A0254	SEAL BAR PRE-ASS'Y	1
2	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	5
3	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" x 0.5" x 600 (2.1)	1
4	051-0581	NUT 1/4"-20 NYLON LOCK S/S	10
5	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	10
6	051-0740	WASHER 1/4" FLAT S/S	8
7	001A1901	EXTERIOR BELLOWS COVER	1
8	002A0357	SEAL BAR SUPPORT	1
9	001A1900	INTERIOR BELLOWS COVER	1
10	001-0269	SEAL BAR GUIDE	2



VUE A

-TWIN SEAL OPTION-

	QTY
700A	4
680A	4
650A	4
MACHINE	QTY

MACHINE: 650A, 680A & 700A

PART: SEAL BAR ASS'Y W/SUPPORT

ITEM

MAT.

DEPT. TOL.	METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

CNC

DEPT. M-I QTY LIST

DWG BY M.A.L. DATE 06-01-16

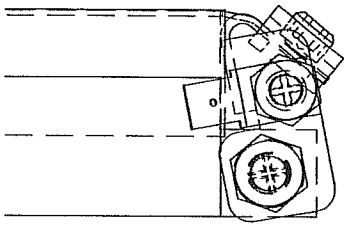
APP. BY DATE 06-08-08

NO. 005B0547

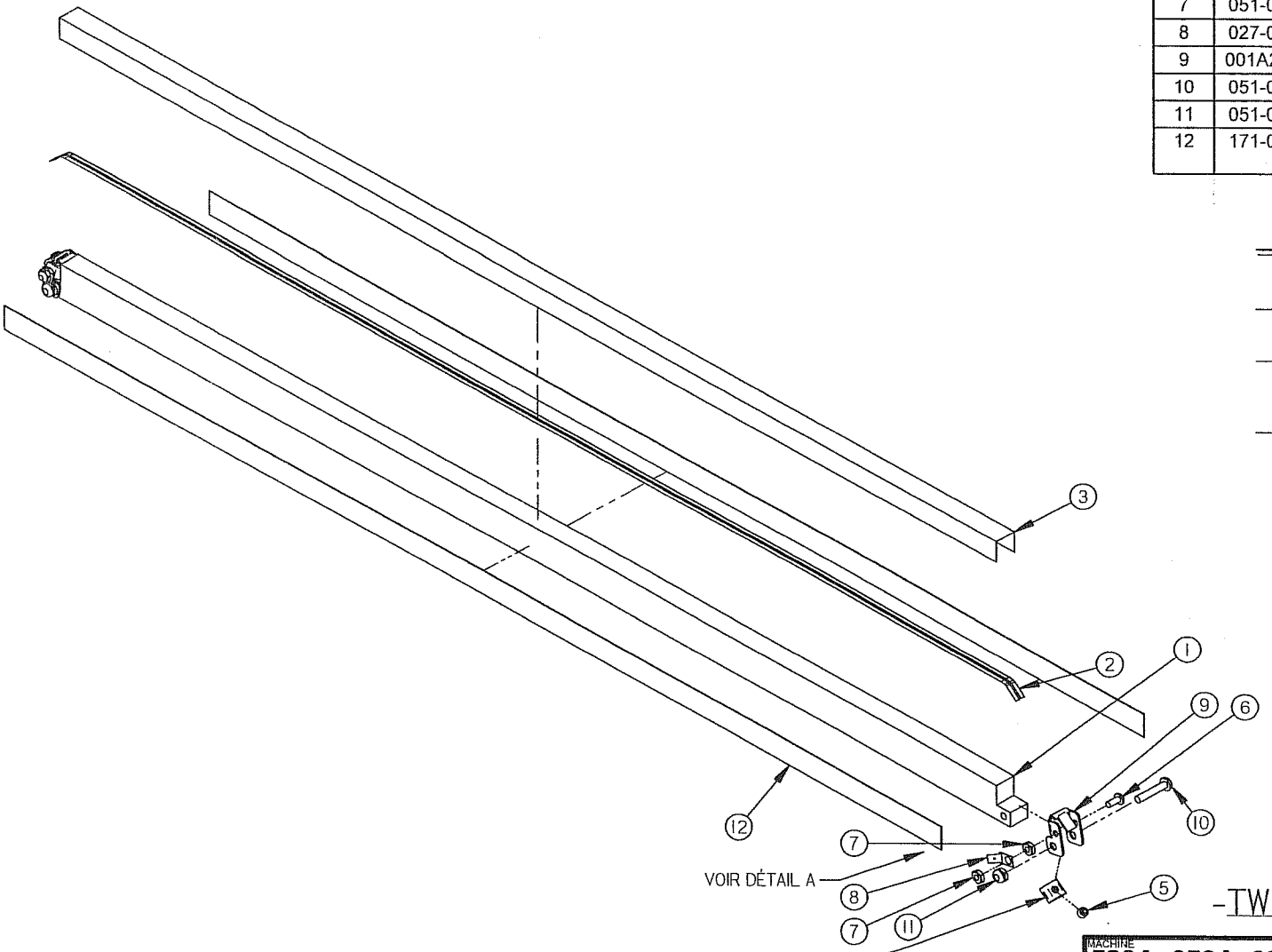
E	REDRAWN	06-01-16	M.A.
ET.	MODIFICATION	DATE	INT.

004A0254

ITEM	PART #	DESCRIPTION	QT.
1	002A0332	SEAL BAR	1
2	039-0268	DOUBLE SEAM BAND (8MM) (3.1)	1
3	176-0200	TEFLON TAPE 5MIL (0.104)	1
4	056-1401	3/8"SET SCREW BANDING BUCKLE S/S	2
5	052-0393	SCREW 1/4-28x3/16"SKT SET OVAL POINT ZINC	2
6	051-0100	SCREW 8-32 X 3/8" PAN PHIL S/S	2
7	051-0550	NUT #8-32 SS	4
8	027-0400	CONNECTOR ADAPTOR	2
9	001A2742	8mm ELEMENT BINDER	2
10	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
11	051-0572	LOCK NUT #10-24 S/S	2
12	171-0180	TAPE CLEAR SUPER BOND 3/4" 854.5mm (0.026)	2



-DÉTAIL A-



-TWIN SEAL OPTION-

MACHINE	QTY
700A	4
680A	4
650A	4
580A	2

INSTALLER CONTRE L'ENCOCHE DE L'ITEM #8 (4) INSTALL AGAINST NOTCH OF ITEM #8

LET.	MODIFICATION	DATE	INT.
E	ADDED 052-0393	06-04-19	M.A.
D	REDRAWN	06-01-16	M.A.

MACHINE: 580A, 650A, 680A & 700A

PART: SEAL BAR PRE-ASS'Y

DEPT. TOL	METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"

N.T.S.

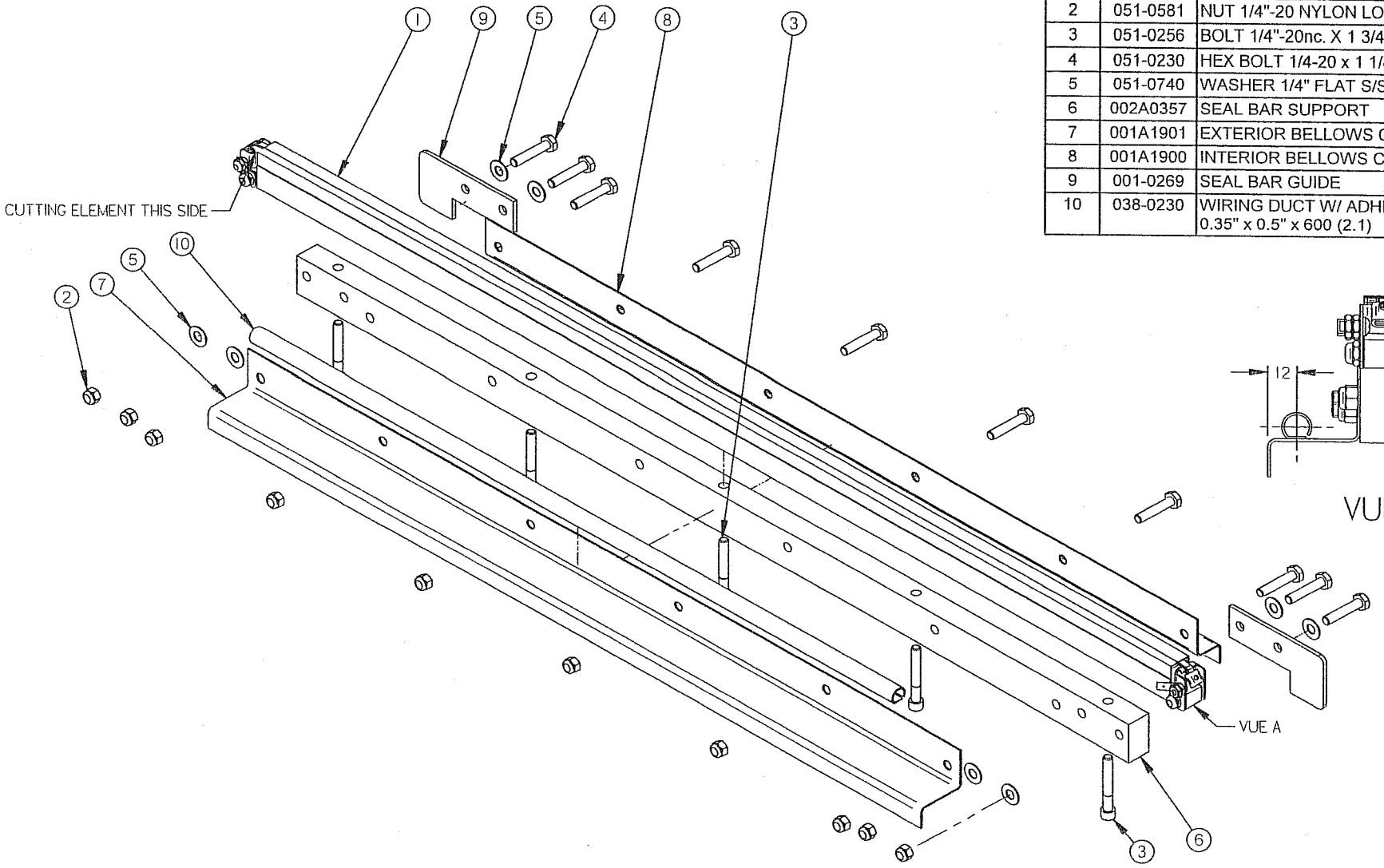
ITEM | CNC | DEPT. M-I | QTY LIST

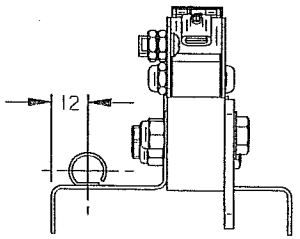
MAT. | DWG BY M.A.L. | DATE 06-01-16 | APP. BY | DATE 06-04-19 | NO 004A0254

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

005B0548

ITEM	PART #	DESCRIPTION	QT.
1	004A0255	SEAL BAR PRE-ASS'Y	1
2	051-0581	NUT 1/4"-20 NYLON LOCK S/S	10
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	5
4	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	10
5	051-0740	WASHER 1/4" FLAT S/S	8
6	002A0357	SEAL BAR SUPPORT	1
7	001A1901	EXTERIOR BELLOWS COVER	1
8	001A1900	INTERIOR BELLOWS COVER	1
9	001-0269	SEAL BAR GUIDE	2
10	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" x 0.5" x 600 (2.1)	1





VUE A

-BAG CUT OPTION-

MACHINE	QTY
700A	4
680A	4
650A	4

MACHINE: 650A, 680A & 700A
PART: SEAL BAR ASS'Y W/SUPPORT
ITEM
MAT.
CNC
DWG BY M.A.L. DATE 06-01-16
APP. BY DATE 06-05-29
DEPT. M-I QTY LIST
NO. 005B0548

DEPT. TOL.	METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"

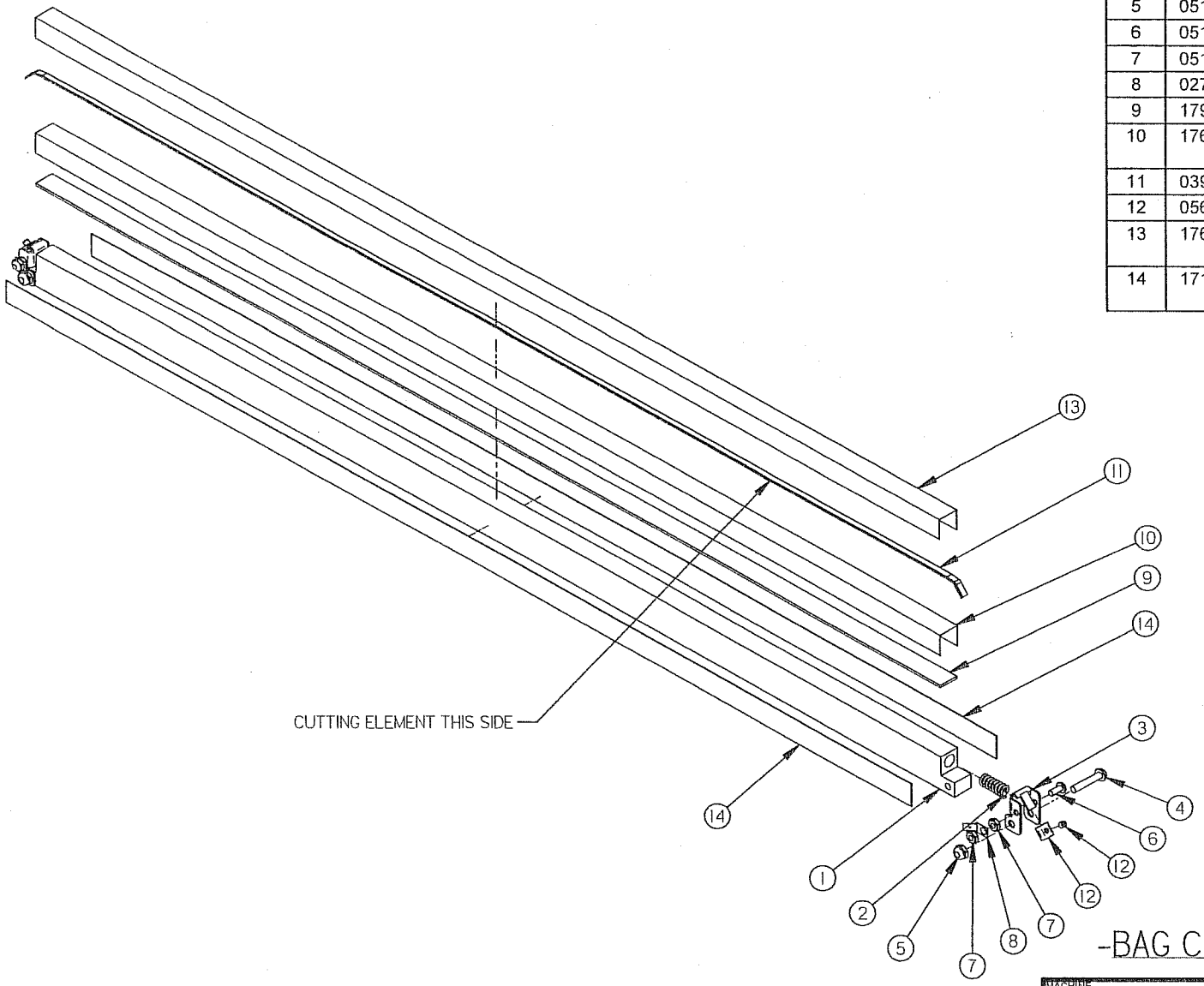
N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

LET.	MODIFICATION	DATE	INT.
F	REDRAWN	06-01-16	M.A.

004A0255

ITEM	PART #	DESCRIPTION	QT.
1	009A0193	ECO SEAL BAR	1
2	077-0095	SPRING C 0360-059-1250 S/S	2
3	001-2666	ELEMENT BINDER	2
4	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
5	051-0572	LOCK NUT #10-24 S/S	2
6	051-0100	SCREW 8-32 X 3/8" PAN PHIL S/S	2
7	051-0550	NUT #8-32 SS	4
8	027-0400	CONNECTOR ADAPTOR	2
9	179-0003	SILICONE 2mm x 15mm ADHESIVE (0.89)	1
10	176-0220	TEFLON TAPE, PRESS SENSITIVE 2" 854.5mm (0.104)	1
11	039-0269	SEAL CUT ELEMENT (0.0892)	1
12	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
13	176-0203	TEFLON TAPE, 5MIL UNCOATED ZONE 854.5mm (0.085)	1
14	171-0180	TAPE CLEAR SUPER BOND 3/4" 854.5mm (0.026)	2



-BAG CUT OPTION-

MACHINE	QTY
700A	4
680A	4
650A	4
580A	2

LET.	MODIFICATION	DATE	INT.
D	REDESSINE	06-01-16	M.A.

MACHINE: 580A, 650A, 680A & 700A

PART: SEAL BAR PRE-ASS'Y

DEPT. TOL	METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"

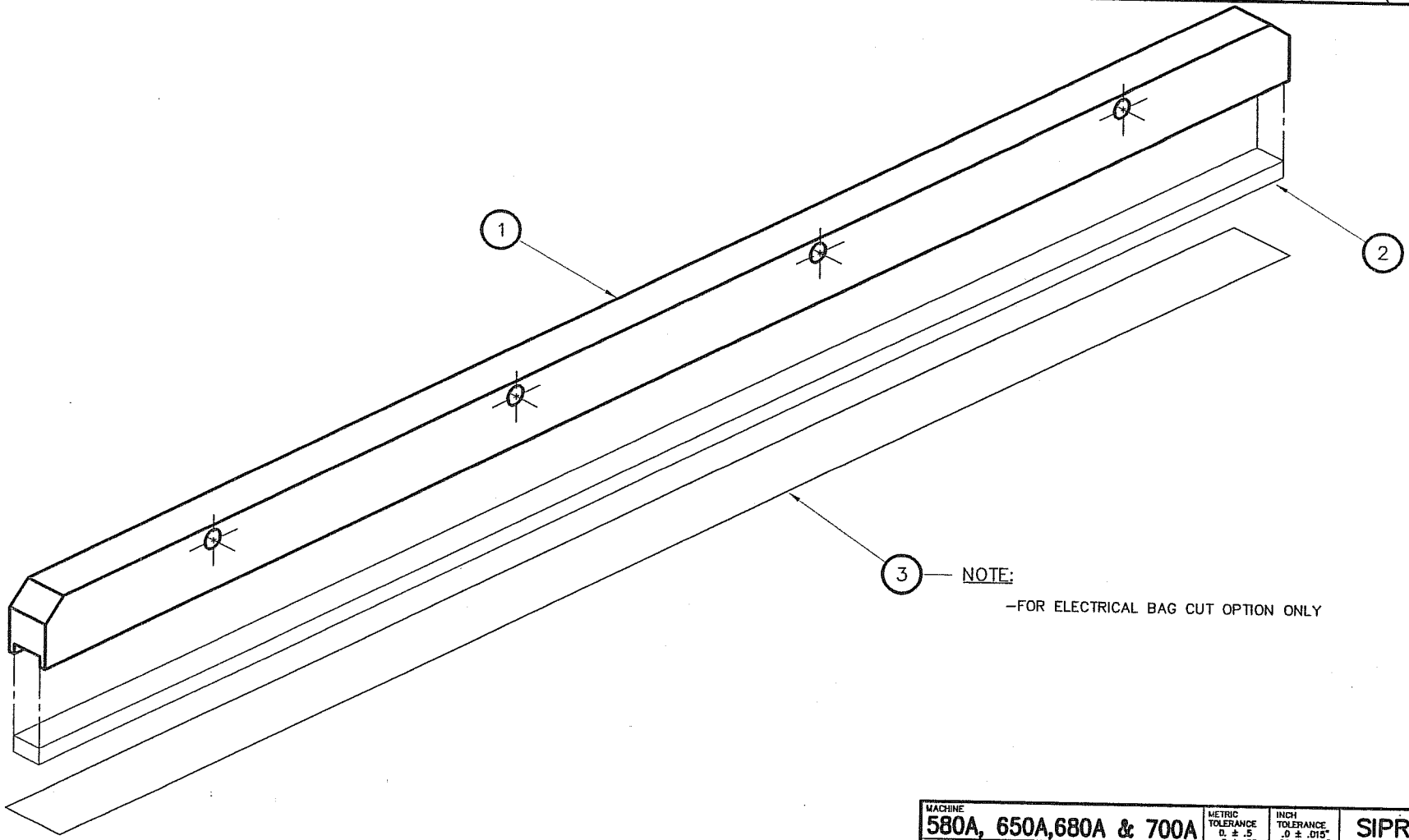
N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

ITEM | CNC | DEPT. M-I | QTY LIST

MAT. | DWG BY M.A.L. | DATE 06-01-16 | APP. BY | DATE 06-05-31 | NO. 004A0255

ITEM	PART #	DESCRIPTION	QT.
1	002B0364	UPPER SEAL BAR SUPPORT	2
2	008-0374	UPPER SEAL BAR RUBBER	2
3	176-0200	TEFLON TAPE (5S) ADHESIVE (2" x 936MM)	0.12



NOTE:

-FOR ELECTRICAL BAG CUT OPTION ONLY

	ADDED 580A	04-11-08	M.A.L.
	ADDED 650A WAS 004B0139	00-02-01	S.L.
	REDRAWN WAS 004A0207	99-08-20	S.L.
T.	MODIFICATION	DATE	INT.

MACHINE: 580A, 650A,680A & 700A

PART: UPPER SEAL BAR ASSEMBLY

ITEM:

MAT:

METRIC TOLERANCE: 0. ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°

INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"

N.T.S.

CNC:

DWG BY: S. LAROUCHE DATE 99-08-20

APP. DATE

SIPROMAC

ST-GERMAIN DE GRANTHAM QUEBEC CANADA

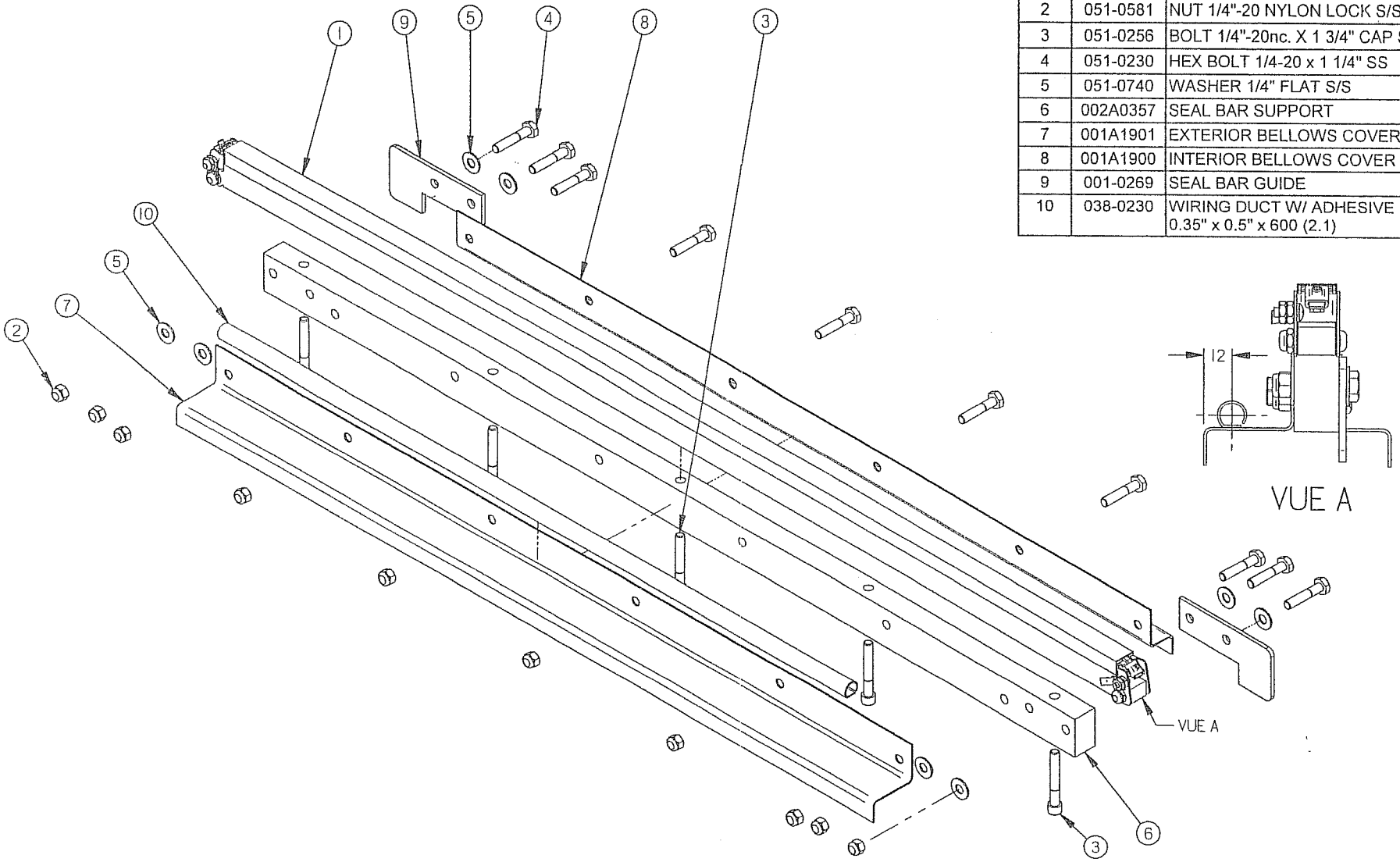
SCALE ——— QT. 2

NO. 004B0207

004B0207

005B0549

ITEM	PART #	DESCRIPTION	QT.
1	004A0256	SEAL BAR PRE-ASS'Y	1
2	051-0581	NUT 1/4"-20 NYLON LOCK S/S	10
3	051-0256	BOLT 1/4"-20nc. X 1 3/4" CAP SKT S/S	5
4	051-0230	HEX BOLT 1/4-20 x 1 1/4" SS	10
5	051-0740	WASHER 1/4" FLAT S/S	8
6	002A0357	SEAL BAR SUPPORT	1
7	001A1901	EXTERIOR BELLOWS COVER	1
8	001A1900	INTERIOR BELLOWS COVER	1
9	001-0269	SEAL BAR GUIDE	2
10	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" x 0.5" x 600 (2.1)	1



VUE A

-TOP & BOTTOM SEALING OPTION-

MACHINE QTY
700A 4
680A 4
650A 4

MACHINE: 650A, 680A & 700A

PART: SEAL BAR ASS'Y W/SUPPORT

DEPT TOL	METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

ITEM | CNC | DEPT. M-I | QTY LIST

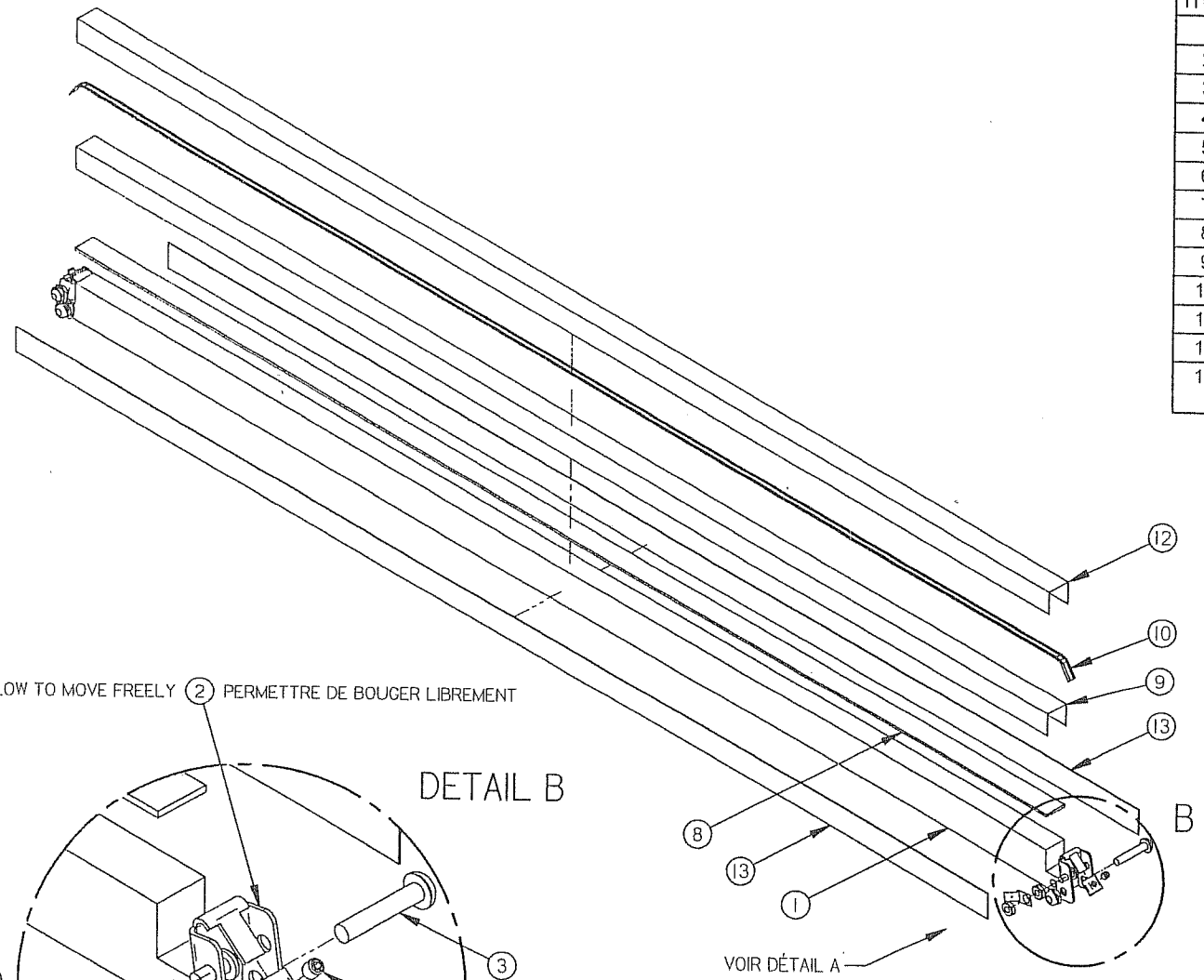
MAT. | DWG BY M.A.L. | DATE 07-12-17 | NO 005B0549

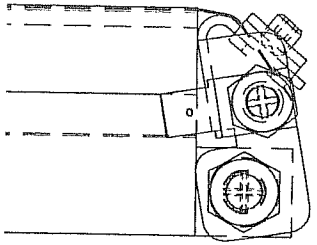
APP. BY | DATE 08-11-06

LET.	MODIFICATION	DATE	INT.
F	REDRAWN	07-12-17	M.A.

004A0256

ITEM	PART #	DESCRIPTION	QT.
1	002A0332	SEAL BAR	1
2	001-2666	ELEMENT BINDER	2
3	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
4	051-0572	LOCK NUT #10-24 S/S	2
5	051-0100	SCREW 8-32 X 3/8" PAN PHIL S/S	2
6	051-0550	NUT #8-32 SS	4
7	027-0400	CONNECTOR ADAPTOR	2
8	179-0003	SILICONE 2mm x 15mm (0.9)	1
9	176-0220	TEFLON TAPE, PRESS SENSITIVE 2" (0.104)	1
10	039-0220	BI-ACTIVE SEALING ELEMENT (0.09)	1
11	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
12	176-0200	TEFLON TAPE 5MIL (0.104)	1
13	171-0180	TAPE CLEAR SUPER BOND 3/4" 854.5mm (0.026)	2

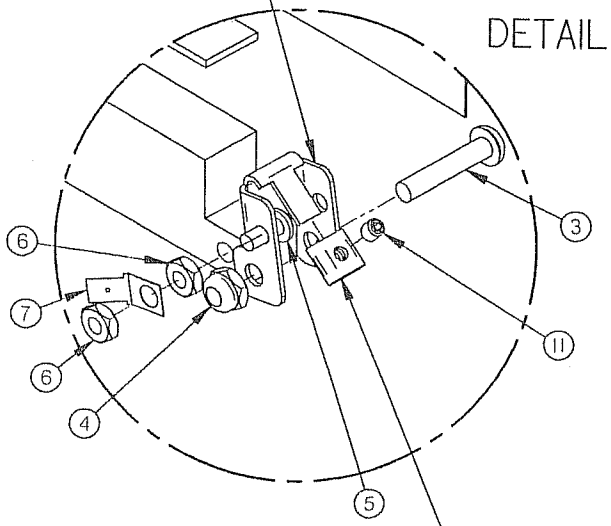




-DÉTAIL A-

ALLOW TO MOVE FREELY (2) PERMETTRE DE BOUGER LIBREMENT

DETAIL B



INSTALLER CONTRE L'ENCOCHE DE L'ITEM #2 (11) INSTALL AGAINST NOTCH OF ITEM #2

-TOP & BOTTOM SEALING OPTION-

MACHINE	QTY
700A	4
680A	4
650A	4
580A	2

MACHINE: 580A, 650A, 680A & 700A

PART: SEAL BAR PRE-ASS'Y

DEPT.	TOL.	METRIC	INCH
USINAGE		± 0.1	± 0.004"
TOLERIE		± 0.5	± 0.020"
SOUDAGE		± 0.5	± 0.020"

N.T.S.

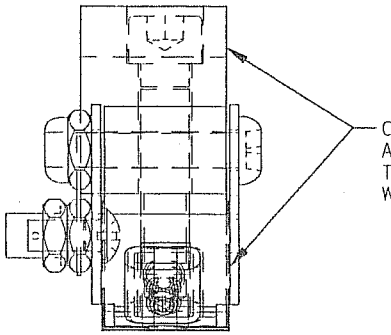
SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

ITEM:
CNC:
DEPT. M-I
QTY LIST
MAT.
DWG BY M.A.L. DATE 07-12-17
APP. BY DATE 28-12-17
NO. 004A0256

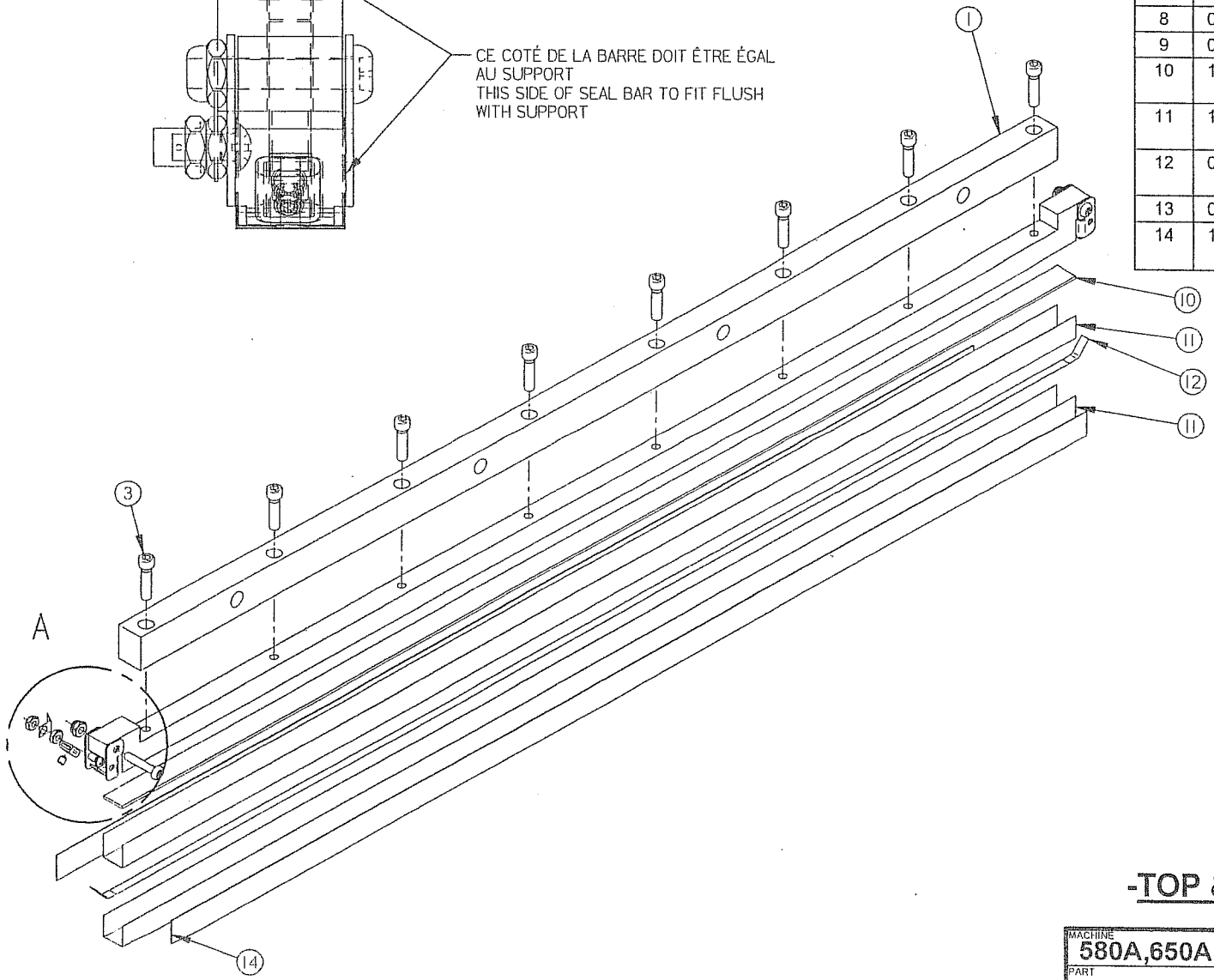
LET.		DATE	INT.
E	REDRAWN	07-12-17	M.A.
	MODIFICATION	DATE	INT.

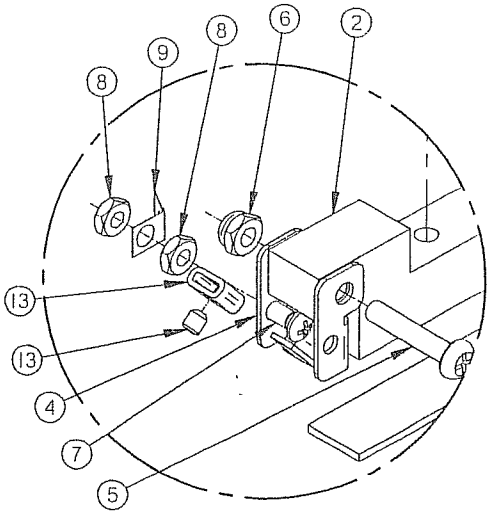
005B0437

ITEM	PART #	DESCRIPTION	QT.
1	002B0378	UPPER SEAL BAR SUPPORT	1
2	002B0396	UPPER SEAL BAR	1
3	051-0220	SCREW ¼"-20nc x 1" SKT. CAP S/S	8
4	001-2666	ELEMENT BINDER	2
5	051-0146	SCREW 10-24 X 1" PAN PHIL S/S	2
6	051-0572	LOCK NUT #10-24 S/S	2
7	051-0104	SCREW 8-32 x 3/8" RND PHIL S/S	2
8	051-0550	NUT #8-32 SS	4
9	027-0400	CONNECTOR ADAPTOR	2
10	179-0003	SILICONE 2mm x 15mm ADHESIVE 828mm (0.83)	1
11	176-0220	TEFLON TAPE, PRESS SENSITIVE 2" 828mm (0.10)	2
12	039-0220	BI-ACTIVE SEALING ELEMENT (6mm) 871mm (0.087)	1
13	056-1400	1/4"SET SCREW BANDING BUCKLE S/S	2
14	171-0180	TAPE CLEAR SUPER BOND 3/4" 795mm (0.024)	2



CE COTÉ DE LA BARRE DOIT ÊTRE ÉGAL AU SUPPORT
THIS SIDE OF SEAL BAR TO FIT FLUSH WITH SUPPORT





DETAIL A

-TOP & BOTTOM SEALING OPTION-

H	REDESSINE	07-12-17	J.G.
LET.	MODIFICATION	DATE	INT.

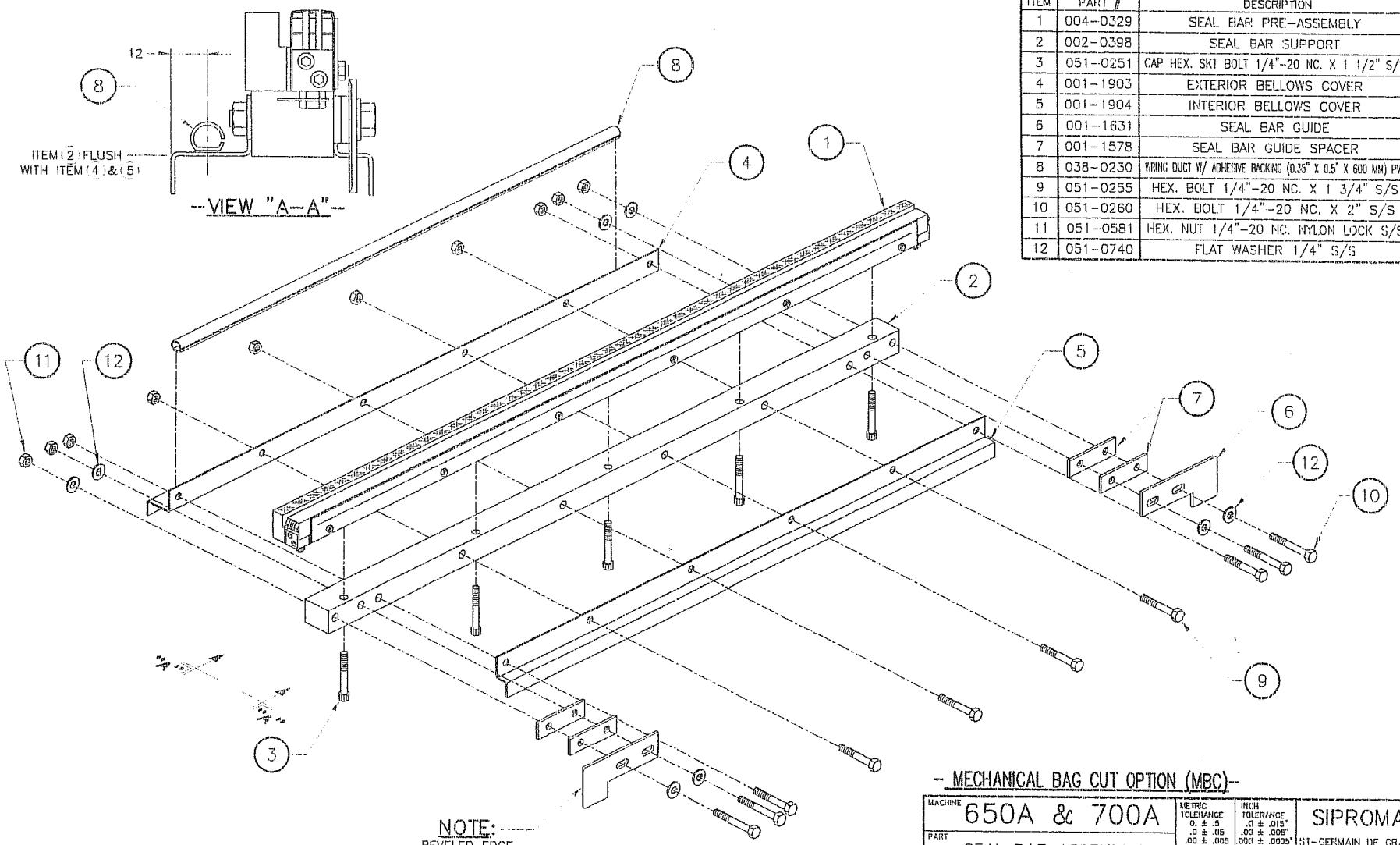
MACHINE: 580A,650A,680A & 700A
PART: UPPER SEAL BAR ASS'Y W/SUPPORT
ITEM:
MAT.:

DEPT. TOL.	METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLERIE	± 0.5	± 0.020"
SOUDAGE	± 0.5	± 0.020"

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

CNC:
DEPT: M-I
QTY: 2
DWG BY: J.G.
DATE: 07-12-17
APP. BY:
DATE: 08-12-62
NO. 005B0437



ITEM	PART #	DESCRIPTION	QT.
1	004-0329	SEAL BAR PRE-ASSEMBLY	1
2	002-0398	SEAL BAR SUPPORT	1
3	051-0251	CAP HEX. SKT BOLT 1/4"-20 NC. X 1 1/2" S/S	5
4	001-1903	EXTERIOR BELLOWS COVER	1
5	001-1904	INTERIOR BELLOWS COVER	1
6	001-1631	SEAL BAR GUIDE	2
7	001-1578	SEAL BAR GUIDE SPACER	4
8	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" X 0.5" X 600 MM) PVC	2.1
9	051-0255	HEX. BOLT 1/4"-20 NC. X 1 3/4" S/S	6
10	051-0260	HEX. BOLT 1/4"-20 NC. X 2" S/S	4
11	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	10
12	051-0740	FLAT WASHER 1/4" S/S	8

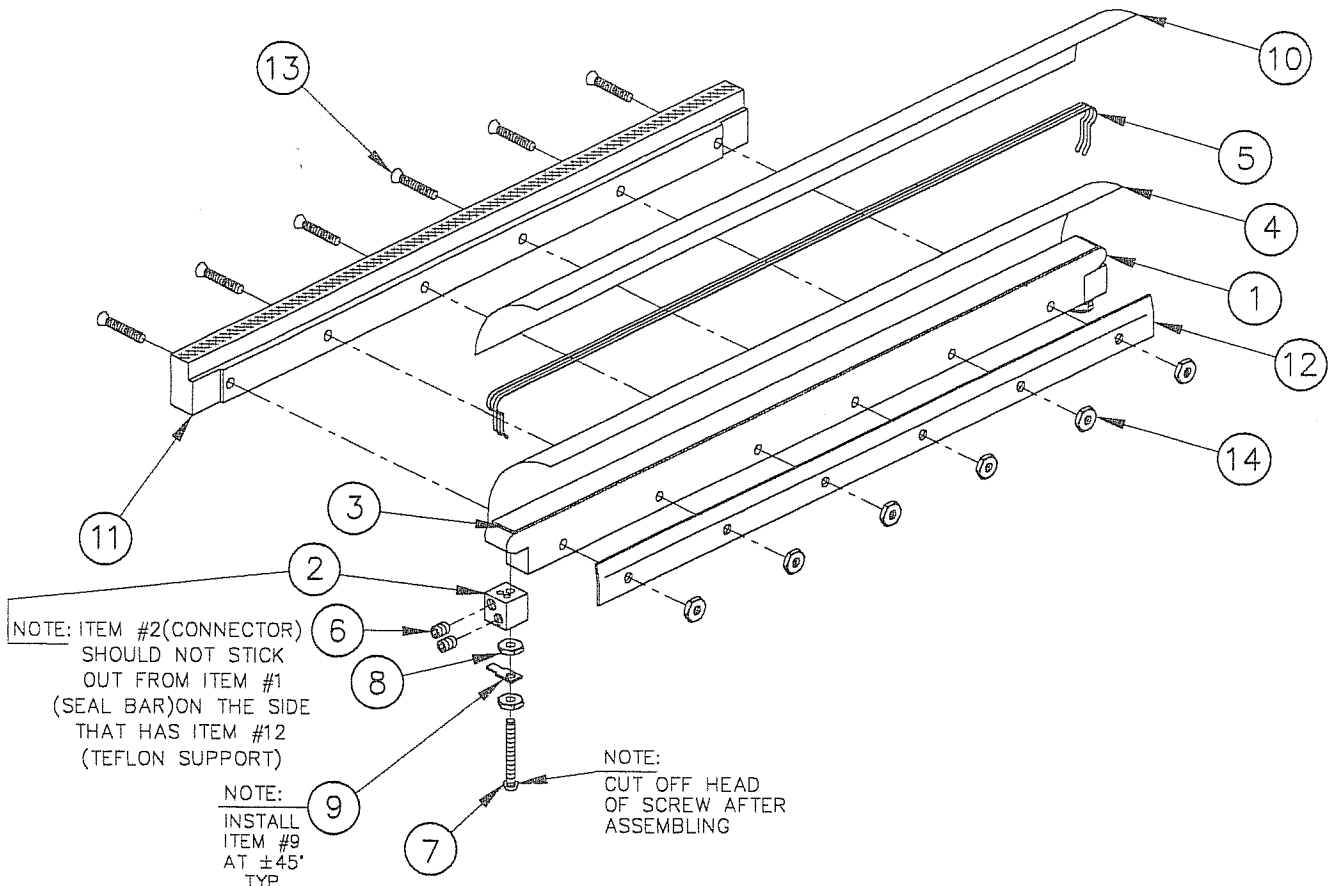
NOTE:
BEVELED EDGE
THIS SIDE TYP. (ITEM 6)

-- MECHANICAL BAG CUT OPTION (MBC)--

LET.	MODIFICATION	DATE	INT.
D	ADDED 650A WAS 005-0366	00-02-07	S.L.
C	REDRAWN/ MODIF. NO. A-0245	98-06-12	A.P.

MACHINE: 650A & 700A	METRIC TOLERANCE: 0. ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE: ± 1°	INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"	SIPROMAC
PART: SEAL BAR ASSEMBLY		N.T.S.	ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM:	CNC:		SCALE: ____ QT. 4
MAT:	DWG BY: A. PROVENCHER DATE: 98-06-12		NO. 005-0550
	APP. DATE		

005-0550



ITEM	PART #	DESCRIPTION	QT.
1	002-0332	SEAL BAR (TABLE)	1
2	002-0031	CONNECTOR	2
3	179-0003	SILICONE 2mm x 15mm ADHESIVE (852mm EA.)	0.890
4	176-0220	TEFLON TAPE (10S) ADHESIVE 862mm	0.109
5	039-0230	REFLEX BAND 2.5mm (992mm EA.)	0.104
6	052-0395	SET SCREW 1/4"-20 x 5/16" (OVAL POINT)	4
7	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	2
8	051-0550	NUT #8-32 S/S	4
9	027-0400	CONNECTOR ADAPTOR	2
10	176-0200	TEFLON TAPE (5S) ADHESIVE (862mm EA.)	0.109
11	002-0339	BAG HOLD BAR	1
12	001-0266	TEFLON SUPPORT (TABLE)	1
13	051-0158	SCREW #10-24 x 1 3/4" FLAT PHILL S/S	6
14	051-0571	NUT #10-24 S/S	6

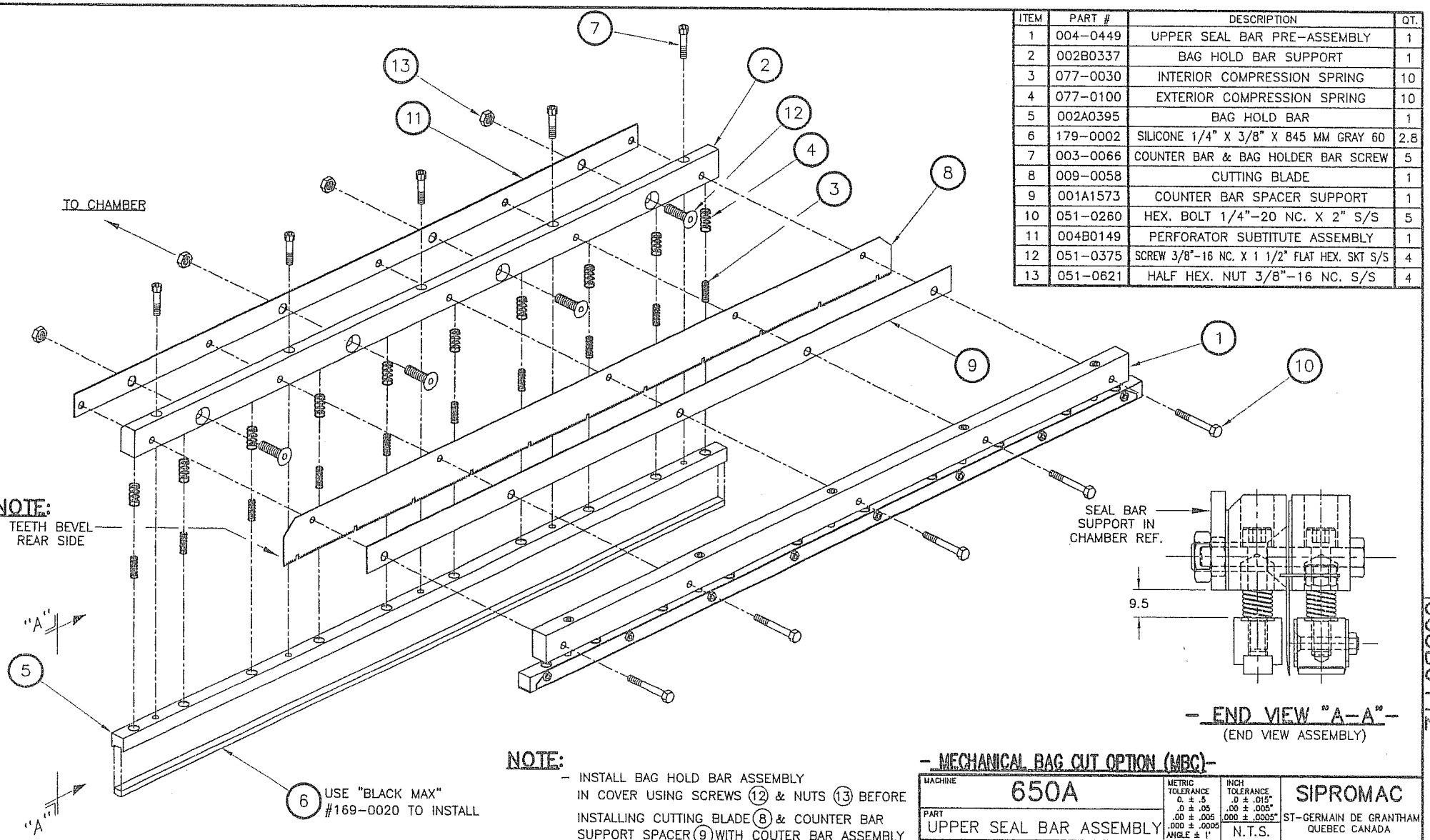
-MECHANICAL BAG CUT OPTION (MBC)-

MACHINE	METRIC TOLERANCE	INCH TOLERANCE	
650A & 700A	0. ± .5 .0 ± .05 .00 ± .005 .000 ± .0005 ANGLE ± 1°	.0 ± .015" .00 ± .005" .000 ± .0005"	SIPROMAC
PART: SEAL BAR PRE-ASS'Y (TABLE)	N.T.S.		ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

ITEM:	CNC:	~~SCALE~~ M	QT. 4
MAT:	DWG BY M. LAVIGNE DATE 96-06-25		NO. 004-0329
	APP. DATE		

LET.	MODIFICATION	DATE	INT.
A	ITEM NO. 5 WAS 039-0200/ MODIF. A-0202	97-05-08	A.P.

004-0329



ITEM	PART #	DESCRIPTION	QT.
1	004-0449	UPPER SEAL BAR PRE-ASSEMBLY	1
2	002B0337	BAG HOLD BAR SUPPORT	1
3	077-0030	INTERIOR COMPRESSION SPRING	10
4	077-0100	EXTERIOR COMPRESSION SPRING	10
5	002A0395	BAG HOLD BAR	1
6	179-0002	SILICONE 1/4" X 3/8" X 845 MM GRAY 60	2.8
7	003-0066	COUNTER BAR & BAG HOLDER BAR SCREW	5
8	009-0058	CUTTING BLADE	1
9	001A1573	COUNTER BAR SPACER SUPPORT	1
10	051-0260	HEX. BOLT 1/4"-20 NC. X 2" S/S	5
11	004B0149	PERFORATOR SUBTITUTE ASSEMBLY	1
12	051-0375	SCREW 3/8"-16 NC. X 1 1/2" FLAT HEX. SKT S/S	4
13	051-0621	HALF HEX. NUT 3/8"-16 NC. S/S	4

- END VIEW "A-A" -
(END VIEW ASSEMBLY)

NOTE:

- INSTALL BAG HOLD BAR ASSEMBLY IN COVER USING SCREWS (12) & NUTS (13) BEFORE INSTALLING CUTTING BLADE (8) & COUNTER BAR SUPPORT SPACER (9) WITH COUTER BAR ASSEMBLY TO BAG HOLD BAR ASSEMBLY WITH BOLT (10) & NUTS (11)

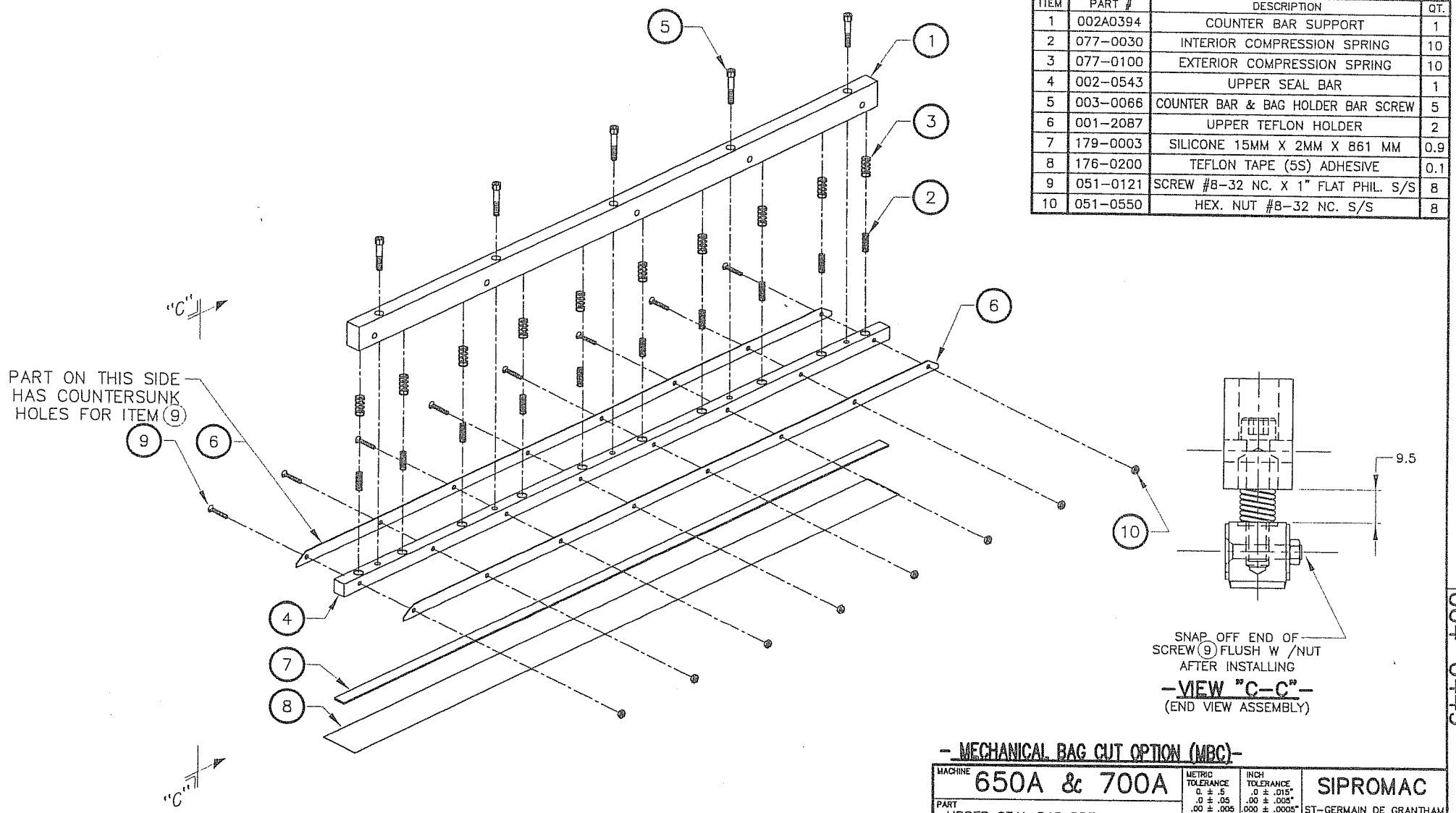
- MECHANICAL BAG CUT OPTION (MBC)-

LET.	MODIFICATION	DATE	INT.
D	REDRAWN	00-02-03	S.L.

MACHINE: 650A
PART: UPPER SEAL BAR ASSEMBLY
METRIC TOLERANCE: 0. ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°
INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA
ITEM:
CNC:
SCALE: M-1
QT. 2
MAT:
DWG BY: SYLVAIN L.
DATE 00-02-03
APP.
DATE Avril-11-03
NO. 005B0442

005B0442

ITEM	PART #	DESCRIPTION	QT.
1	002A0394	COUNTER BAR SUPPORT	1
2	077-0030	INTERIOR COMPRESSION SPRING	10
3	077-0100	EXTERIOR COMPRESSION SPRING	10
4	002-0543	UPPER SEAL BAR	1
5	003-0066	COUNTER BAR & BAG HOLDER BAR SCREW	5
6	001-2087	UPPER TEFLON HOLDER	2
7	179-0003	SILICONE 15MM X 2MM X 861 MM	0.9
8	176-0200	TEFLON TAPE (5S) ADHESIVE	0.1
9	051-0121	SCREW #8-32 NC. X 1" FLAT PHIL. S/S	8
10	051-0550	HEX. NUT #8-32 NC. S/S	8



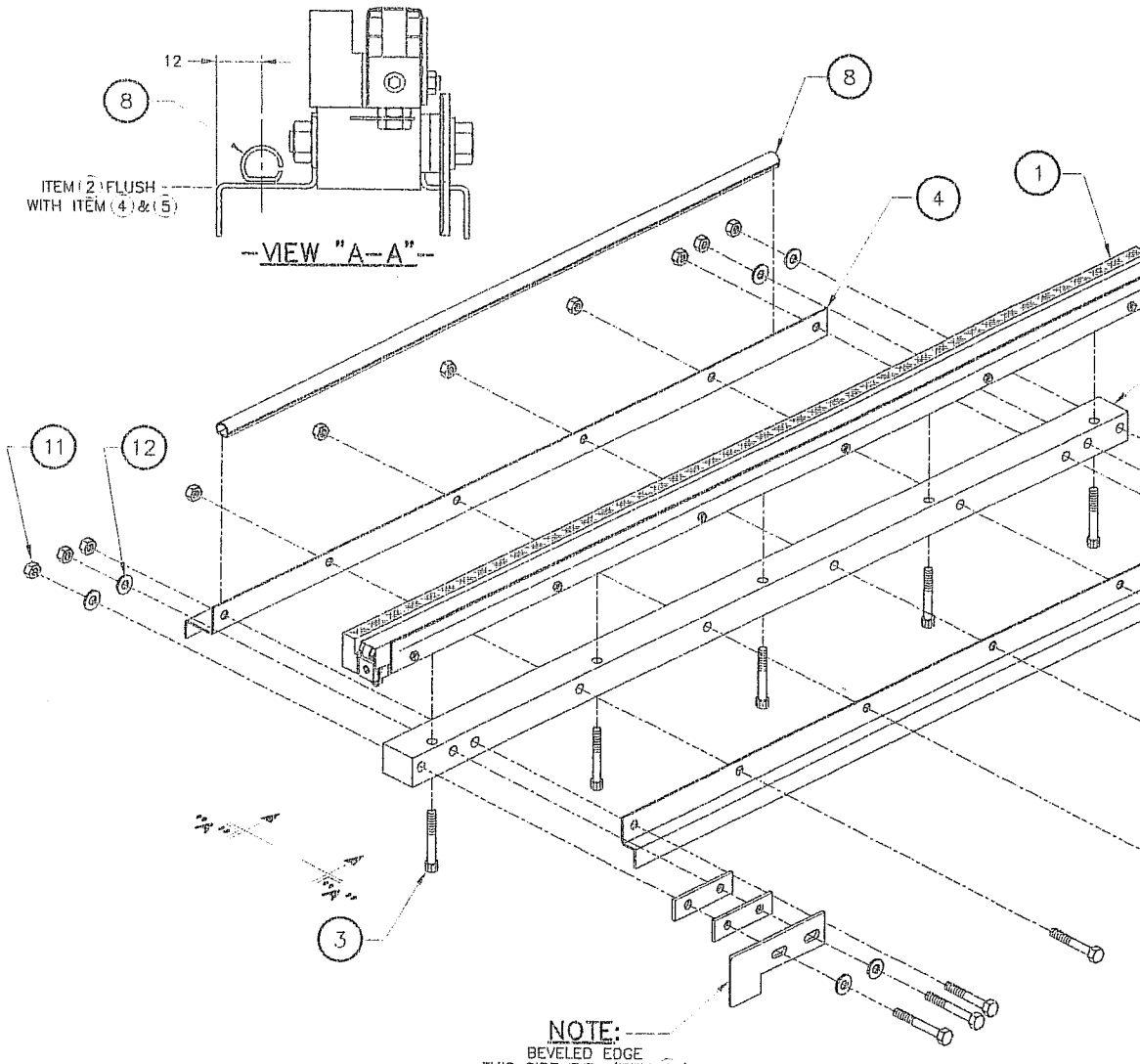
-VIEW "C-C"-
(END VIEW ASSEMBLY)

- MECHANICAL BAG CUT OPTION (MBC)-

B	ADDED 650A WAS 004-0457	00-02-07	S.L.
A	WAS 005-0440	98-06-16	A.P.
ET.	MODIFICATION	DATE	INT.

MACHINE: 650A & 700A
PART: UPPER SEAL BAR PRE-ASSEMBLY
METRIC TOLERANCE: 0. ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°
INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"
N.T.S.
SIPROMAC
ST-GERMAIN DE GRANTHAM QUEBEC CANADA
ITEM:
CNC:
SCALE M-1
QT. 2
MAT:
DWG BY A. PROVENCHER DATE 98-06-16
APP. DATE
NO. 004-0449

004-0449



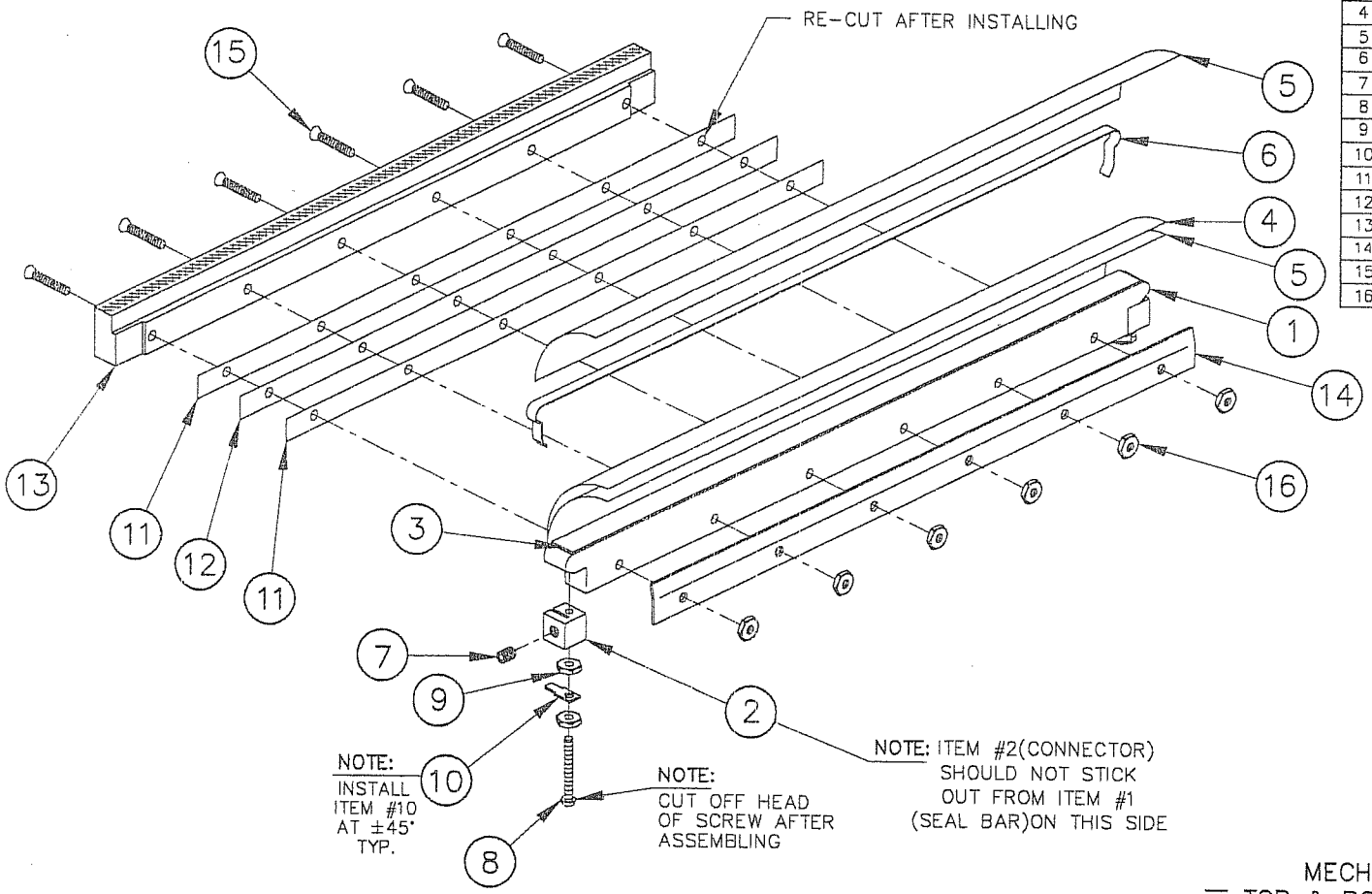
ITEM	PART #	DESCRIPTION	QT.
1	004-0330	SEAL BAR PRE-ASSEMBLY (TBS)	1
2	002-0398	SEAL BAR SUPPORT	1
3	051-0251	CAP HEX. SKT BOLT 1/4"-20 NC. X 1 1/2" S/S	5
4	001-1903	EXTERIOR BELLOWS COVER	1
5	001-1904	INTERIOR BELLOWS COVER	1
6	001-1631	SEAL BAR GUIDE	2
7	001-1578	SEAL BAR GUIDE SPACER (3 MM THK. ONLY)	4
8	038-0230	WIRING DUCT W/ ADHESIVE BACKING (0.35" X 0.5" X 600 MM) PVC	2.1
9	051-0255	HEX. BOLT 1/4"-20 NC. X 1 3/4" S/S	6
10	051-0260	HEX. BOLT 1/4"-20 NC. X 2" S/S	4
11	051-0581	HEX. NUT 1/4"-20 NC. NYLON LOCK S/S	10
12	051-0740	FLAT WASHER 1/4" S/S	8

LET.	MODIFICATION	DATE	INT.
C	ADDED 650A WAS 005-0368	00-02-07	S.L.
B	REDRAWN/ MODIF. NO. A-0245	98-06-12	A.P.

-MECHANICAL BAG CUT TOP & BOTTOM SEALING OPTION (MBCTBS)-

MACHINE: 650A & 700A	METRIC TOLERANCE: 0. ± .0, .0 ± .05, .00 ± .005, .000 ± .0005, ANGL. ± 1°	INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005", N.T.S.	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: SEAL BAR ASSEMBLY			
ITEM:	CHG:	SCALE	QT. 4
MAT:	DWG BY A. PROVENCHER	DATE 98-06-12	NO. 005-0551
	APP.	DATE	

005-0551



ITEM	PART #	DESCRIPTION	QT.
1	002-0332	SEAL BAR (TABLE)	1
2	009-0029	CONNECTOR	2
3	179-0003	SILICONE 2mm x 15mm ADHESIVE (852mm EA.)	0.890
4	176-0220	TEFLON TAPE (10S) ADHESIVE (862mm EA.)	0.109
5	176-0200	TEFLON TAPE (5S) ADHESIVE (2x862mm)	0.218
6	039-0220	BI-ACTIVE SEALING ELEM. (992mm EA.)	0.104
7	052-0395	SET SCREW 1/4"-20 x 5/16" (OVAL POINT)	2
8	052-0250	SCREW #8-32 x 1 1/2" RND SLOT BRASS	2
9	051-0550	NUT #8-32 S/S	4
10	027-0400	CONNECTOR ADAPTOR	2
11	176-0200	STRIP TEFLON TAPE (5S) ADHESIVE (2x862mm)	0.218
12	176-0220	STRIP TEFLON TAPE (10S) ADHESIVE (862mm EA.)	0.109
13	002-0339	BAG HOLD BAR	1
14	001-0266	TEFLON SUPPORT(TABLE)	1
15	051-0158	SCREW #10-24 x 1 3/4" FLAT PHILL S/S	6
16	051-0571	NUT #10-24 S/S	6

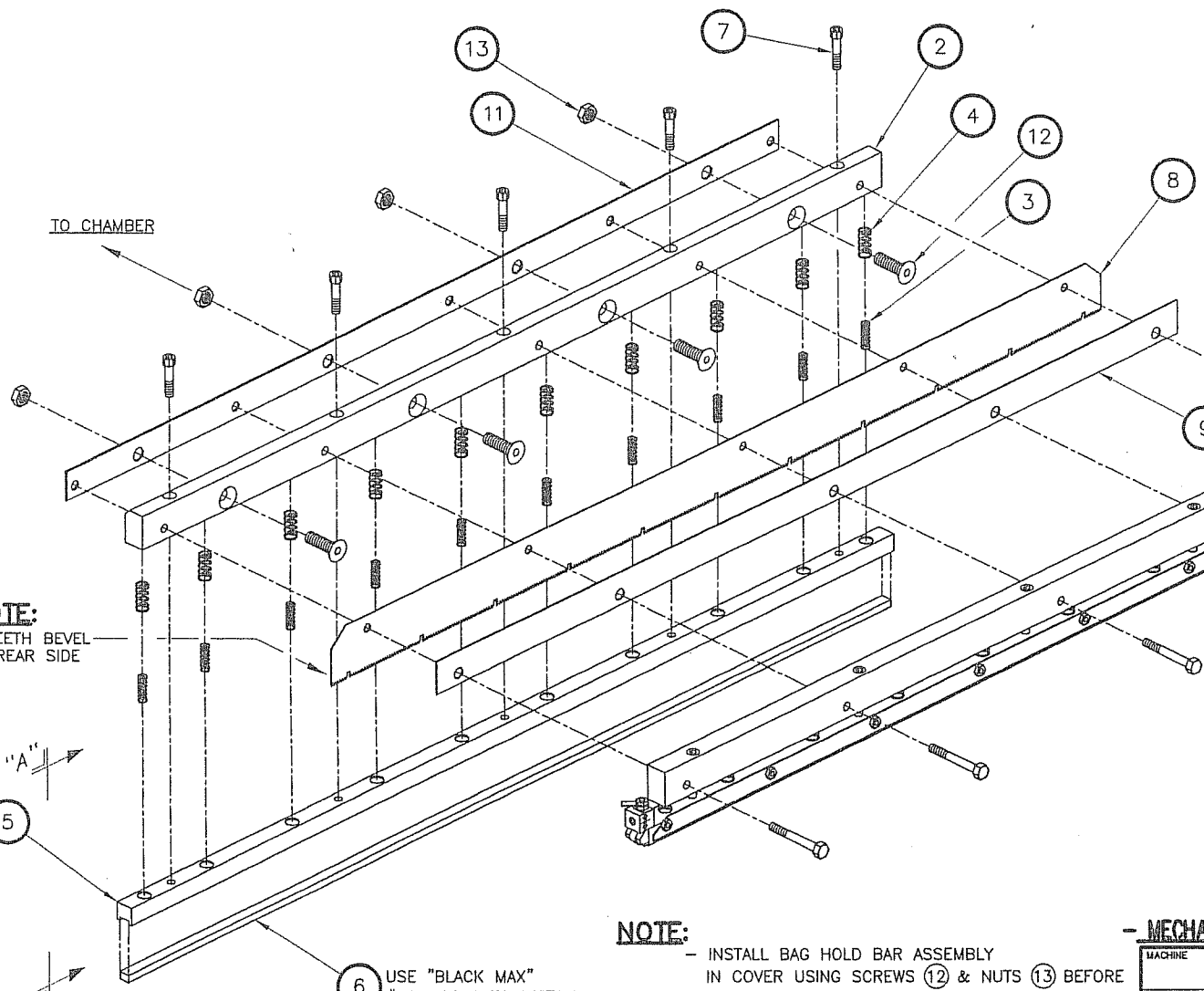
MECHANICAL BAG CUT
TOP & BOTTOM SEALING OPTION
(MBCTBS)

LET.	MODIFICATION	DATE	INT.
A	REDRAWN / ITEM NO.11 & 12 ADDED/ ITEM NO. 14 QTY WAS 8	97-02-06	A.P.

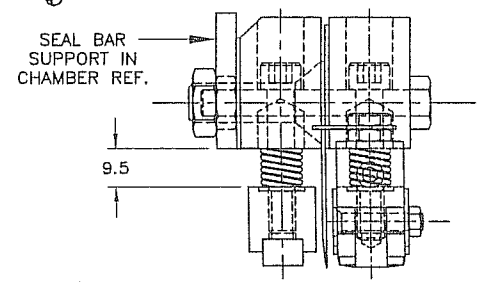
MACHINE: 650A & 700A	METRIC TOLERANCE: 0 ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°	INCH TOLERANCE: 0 ± .015", .00 ± .005", .000 ± .0005"	SIPROMAC ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
PART: SEAL BAR PRE-ASS'Y (TABLE)	N.T.S.		
ITEM:	CNC:	SCALE: M	QT. 4
MAT:	DWG BY: A. PROVENCHER DATE: 97-02-06	APP. DATE	NO. 004-0330

004-0330

ITEM	PART #	DESCRIPTION	QT.
1	004A0332	UPPER SEAL BAR PRE-ASSEMBLY	1
2	002B0337	BAG HOLD BAR SUPPORT	1
3	077-0030	INTERIOR COMPRESSION SPRING	10
4	077-0100	EXTERIOR COMPRESSION SPRING	10
5	002A0395	BAG HOLD BAR	1
6	179-0002	SILICONE 1/4" X 3/8" X 845 MM GRAY 60	2.9
7	003-0066	COUNTER BAR & BAG HOLDER BAR SCREW	5
8	009-0058	CUTTING BLADE	1
9	001A1573	COUNTER BAR SPACER SUPPORT	1
10	051-0260	HEX. BOLT 1/4"-20 NC. X 2" S/S	5
11	004B0149	PERFORATOR SUBTITUTE ASSEMBLY	1
12	051-0375	SCREW 3/8"-16 NC. X 1 1/2" FLAT HEX. SKT S/S	4
13	051-0621	HALF HEX. NUT 3/8"-16 NC. S/S	4



NOTE:
TEETH BEVEL REAR SIDE



- END VIEW "A-A" -
(END VIEW ASSEMBLY)

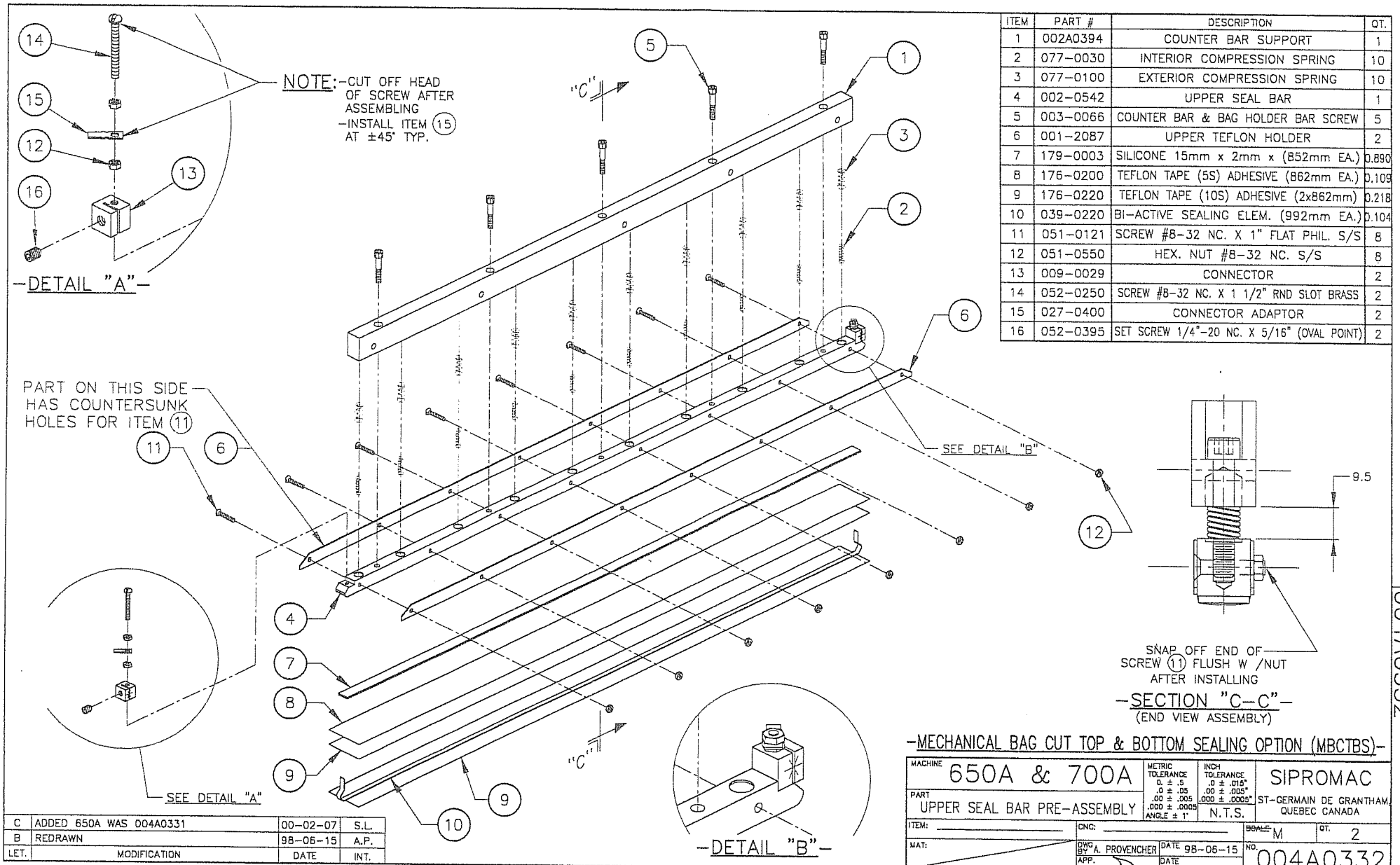
NOTE:
- INSTALL BAG HOLD BAR ASSEMBLY IN COVER USING SCREWS (12) & NUTS (13) BEFORE INSTALLING CUTTING BLADE (8) & COUNTER BAR SUPPORT SPACER (9) WITH COUTER BAR ASSEMBLY TO BAG HOLD BAR ASSEMBLY WITH BOLT (10) & NUTS (11)

- MECHANICAL BAG CUT TOP & BOTTOM SEALING OPTION (MBCTBS) -

LET.	MODIFICATION	DATE	INT.
C	REDRAWN	00-02-07	S.L.

MACHINE: 650A	METRIC TOLERANCE 0. ± .5 / .0 ± .05 / .00 ± .005 / .000 ± .0005 / ANGLE ± 1°	INCH TOLERANCE .0 ± .015" / .00 ± .005" / .000 ± .0005"	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: UPPER SEAL BAR ASSEMBLY	N.T.S.		
ITEM:	CNC:		SCALE:	QT. 2
MAT:	DWG BY: SYLVAIN L.	DATE 00-02-07	NO. 005B0443
	APP.	DATE	

005B0443



ITEM	PART #	DESCRIPTION	QT.
1	002A0394	COUNTER BAR SUPPORT	1
2	077-0030	INTERIOR COMPRESSION SPRING	10
3	077-0100	EXTERIOR COMPRESSION SPRING	10
4	002-0542	UPPER SEAL BAR	1
5	003-0066	COUNTER BAR & BAG HOLDER BAR SCREW	5
6	001-2087	UPPER TEFLON HOLDER	2
7	179-0003	SILICONE 15mm x 2mm x (852mm EA.)	0.890
8	176-0200	TEFLON TAPE (5S) ADHESIVE (862mm EA.)	0.109
9	176-0220	TEFLON TAPE (10S) ADHESIVE (2x862mm)	0.218
10	039-0220	BI-ACTIVE SEALING ELEM. (992mm EA.)	0.104
11	051-0121	SCREW #8-32 NC. X 1" FLAT PHIL. S/S	8
12	051-0550	HEX. NUT #8-32 NC. S/S	8
13	009-0029	CONNECTOR	2
14	052-0250	SCREW #8-32 NC. X 1 1/2" RND SLOT BRASS	2
15	027-0400	CONNECTOR ADAPTOR	2
16	052-0395	SET SCREW 1/4"-20 NC. X 5/16" (OVAL POINT)	2

LET.	MODIFICATION	DATE	INT.
C	ADDED 650A WAS 004A0331	00-02-07	S.L.
B	REDRAWN	98-06-15	A.P.

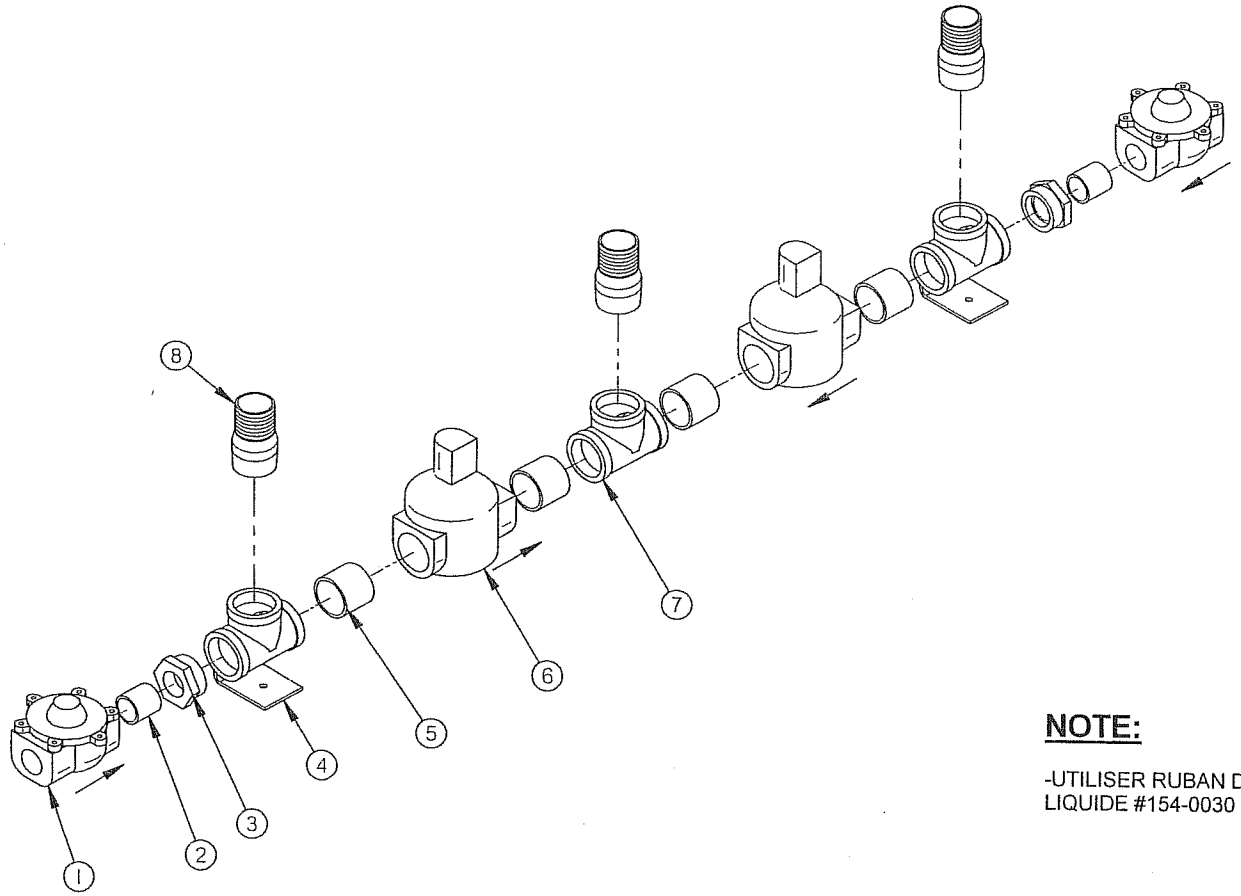
-MECHANICAL BAG CUT TOP & BOTTOM SEALING OPTION (MBCTBS)-

MACHINE: 650A & 700A	METRIC TOLERANCE: 0. ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°	INCH TOLERANCE: .0 ± .015", .00 ± .005", .000 ± .0005"	SIPROMAC
PART: UPPER SEAL BAR PRE-ASSEMBLY		N.T.S.	ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
ITEM:	CNC:	SCALE: M	QT. 2
MAT:	DWG BY: A. PROVENCHER	DATE 98-06-15	NO. 004A0332
	APP.	DATE	

004A0332

004-0505

ITEM	PART #	DESCRIPTION	QT.
1	106-0050	VALVE 2WAY 24V 1-1/4"NPT(B60)60Hz	2
2	103-0247	CLOSE NIPPLE 1 1/4" NPT ZINC	2
3	103-0587	RED. BUSH. 2"npt. X 1 1/4"npt ZINC	2
4	004A1621	VAC./ATM. VALVE SUPP. PRE-ASS'Y	2
5	103-0260	CLOSE NIPPLE 2"NPT ZINC	4
6	106-0060	VALVE 2WAY / 24V / 60Hz / 2" NPT	2
7	103-0487	T 2" NPT GALV.	1
8	103-0760	STRAIGHT 2"mnpt. X 2" HOSE ZINC	3



NOTE:

-UTILISER RUBAN DE TEFLON #154-0060 & TEFLON LIQUIDE #154-0030 POUR L'ASSEMBLAGE.

LET.	MODIFICATION	DATE	INT.
H	REMOVED SORT AIR OPTION NOTE	05-10-31	M.A.
G	004A1621 WAS 004-0183	05-09-27	M.A.
F	REMOVED 2 ITEMS 103-0092	05-09-21	M.A.
E	REDESSINE ET AJOUT OPTION	04-03-03	B.C.

MACHINE: 650A, 680A & 700A

PART: VACUUM / ATMOSPHERE VALVE ASSY

DEPT. TOL	METRIC	INCH
USINAGE	± 0.1	± 0.004"
TOLÉRIE	± 0.5	± 0.030"
SOUDAGE	± 0.5	± 0.020"

N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM
QUEBEC CANADA

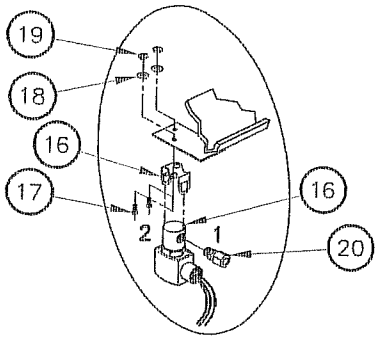
ITEM | CNC | DEPT. M-I | QTY. 1

MAT.

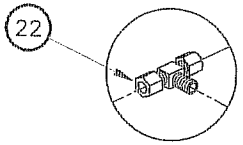
DWG BY B.C. DATE 04-03-03

APP. BY DATE 05-11-04

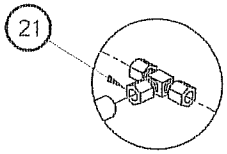
NO. 004-0505



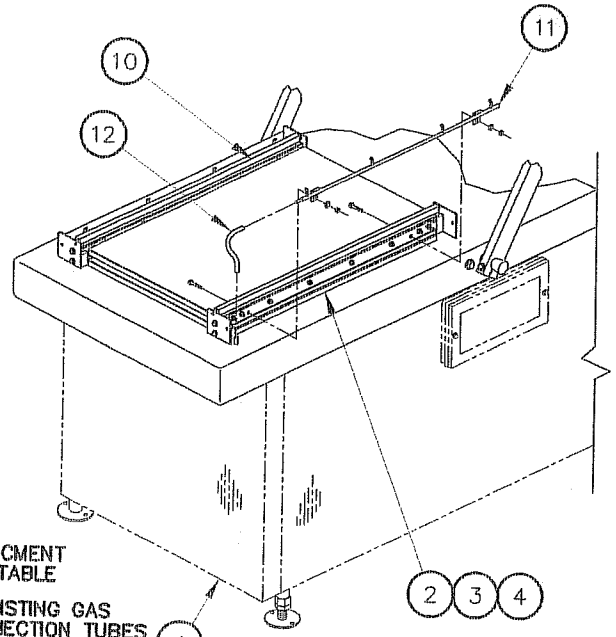
-DETAIL "A"-



-DETAIL "B"-

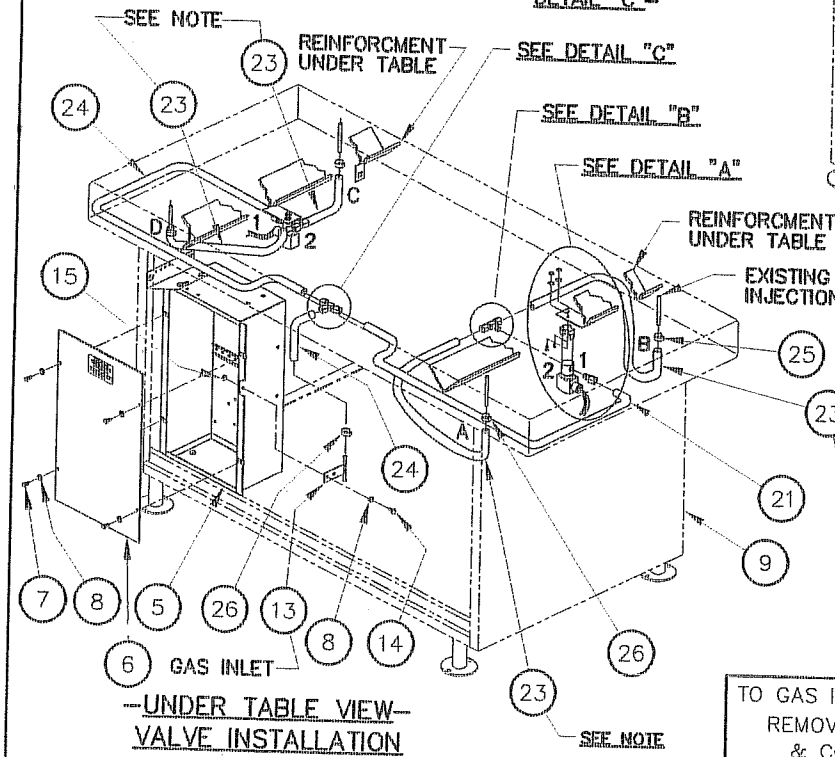


-DETAIL "C"-



-FRONT VIEW-
GAS INJECTION BAR INSTALLATION

ITEM	PART #	DESCRIPTION	QT.
1	005-0352	MACHINE ASSEMBLY FRONT VIEW	1
2	005A0357	SEAL BAR ASS'Y W/ SUPPORT	4
3	005A0358	SEAL BAR ASS'Y W/ SUPPORT (BAG CUT OPT.)	4
4	005A0562	SEAL BAR ASS'Y W/ SUPPORT (T&B OPT.)	4
5	005-0374	ELECTRICAL BOX ASSEMBLY	1
6	004-0279	ELECTRICAL BOX COVER PRE-ASS'Y	1
7	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S	4
8	051-0740	FLAT WASHER 1/4"ø S/S	5
9	005-0353	MACHINE ASSEMBLY REAR VIEW	1
10	005A0350	GAS INJECTION BAR ASS'Y (OPT.)	2
11	005A0814	GAS INJECTION BAR ASS'Y (OPT.)	2
12	008-0464	GAS INJECTION CONN. TUBE (OPTION)	4
13	005-0323	GAS INLET ASSEMBLY	1
14	051-0180	HEX. BOLT 1/4"-20 NC. X 1/2" S/S (OPTION)	1
15	051-0580	HEX. NUT 1/4"-20 NC. S/S (OPTION)	1
16	106-0010	SELENOIDE VALVE 2 WAY 1/4" NPT W/ SUPP.	2
17	051-0100	SCREW #8-32 X 3/8" PAN PHILL. S/S	4
18	051-0720	FLAT WASHER #8 S/S	4
19	051-0550	HEX. NUT #8 S/S	4
20	101-0036	STRAIGHT 1/4" MNPT X 3/8" T.P.COMP.	2
21	101-0062	"T" 3/8" T.P.COMP.	1
22	101-0065	"T" 3/8" T.P.COMP. X 1 /4" MNPT X 3/8" T.P.COMP.	2
23	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm. LG.	4
24	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm. LG.	2
25	104-0060	TUBE 3/8" O.D. X 1/4" I.D. (POLY.) mm. LG.	1
26	105-0200	COLLARS 3/8"ø	5



-UNDER TABLE VIEW-
VALVE INSTALLATION

NOTE: PARTS (1) THRU (9) ARE EXISTING PARTS
PARTS (10) THRU (26) ARE PARTS SUPPLIED W/ KIT

TO GAS INJECTION TUBES UNDER TABLE, REMOVE THE FOUR EXISTING CAPS & CONNECT HOSES A,B,C & D

LET.	MODIFICATION	DATE	INT.
D	MODIFICATION #A-358	03-02-21	J.G.
C	REDRAWN/ MODIF. A-0238	98-02-19	A.P.

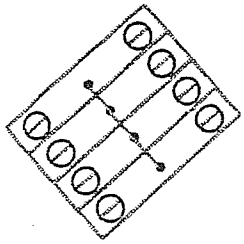
-OPTION GAS INJECTION-

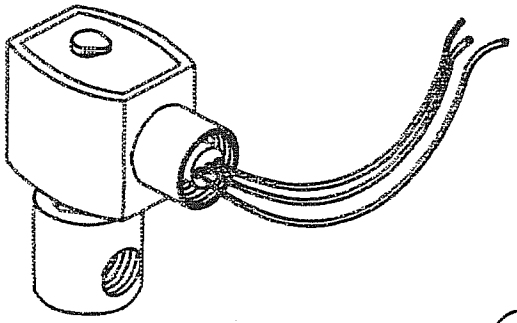
MACHINE: 650A	METRIC TOLERANCE 0. ± .5, .0 ± .05, .00 ± .005, .000 ± .0005, ANGLE ± 1°	INCH TOLERANCE .0 ± .015", .00 ± .005", .000 ± .0005"	SIPROMAC ST-GERMAIN DE GRANTHAM QUEBEC CANADA
PART: GAS INJECTION KIT INSTALLATION		N.T.S.	
ITEM:	CNC:		SCALE M-P-I DT. 1
MAT:	DWG BY A. PROVENCHER DATE 98-02-19		NO. 010-0020
	APP. LT DATE		

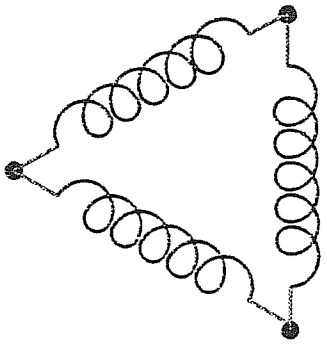
010-0020

NOTES:

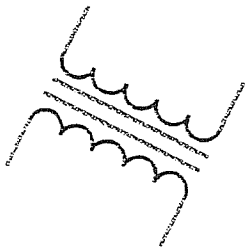
SIPROMAC

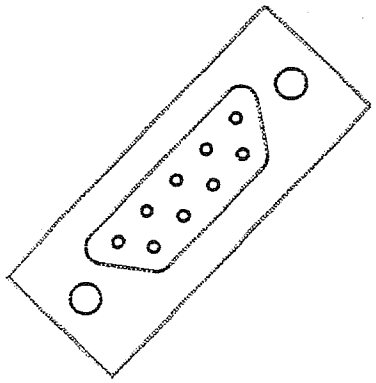


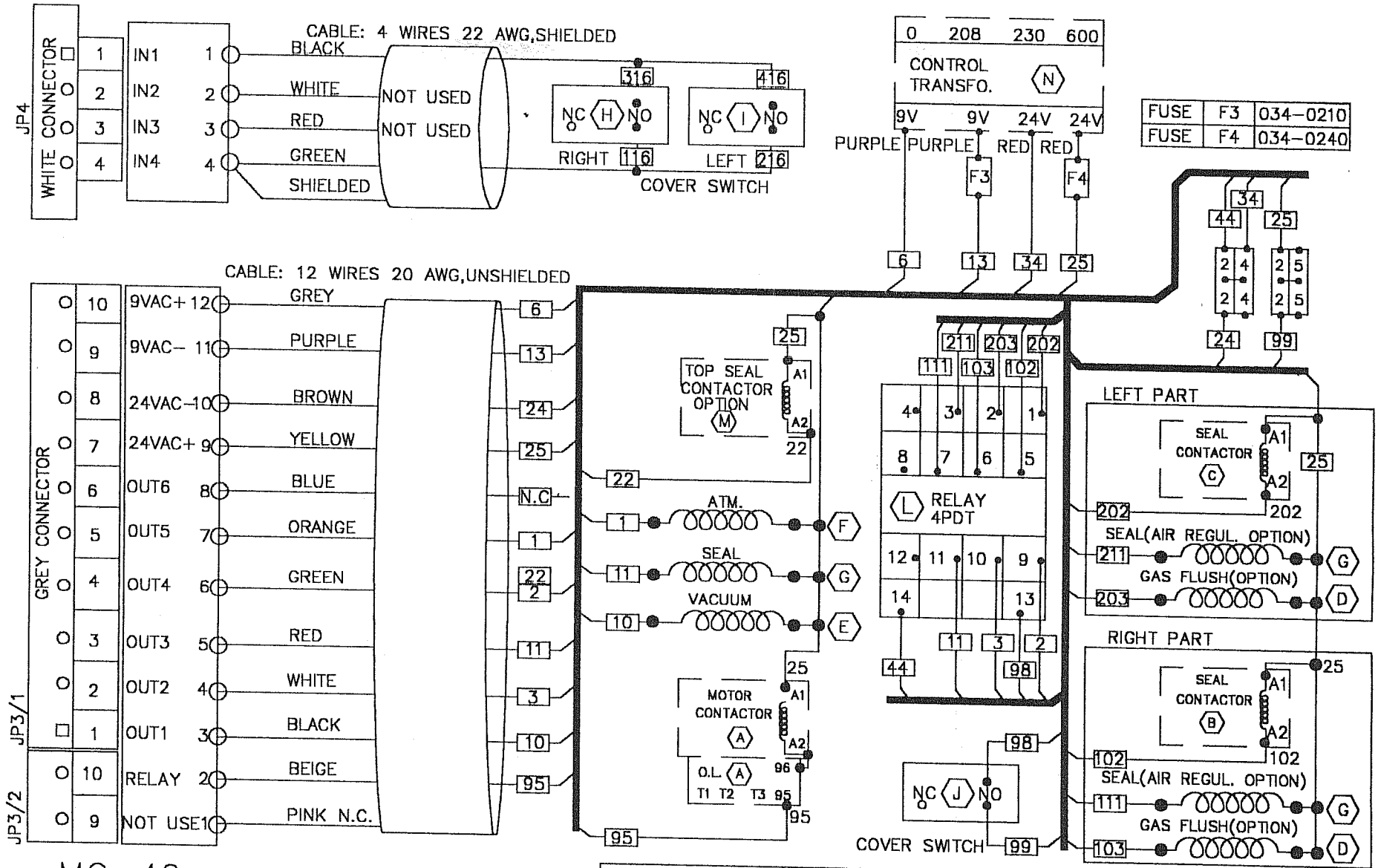




ELECTRICAL DRAWING







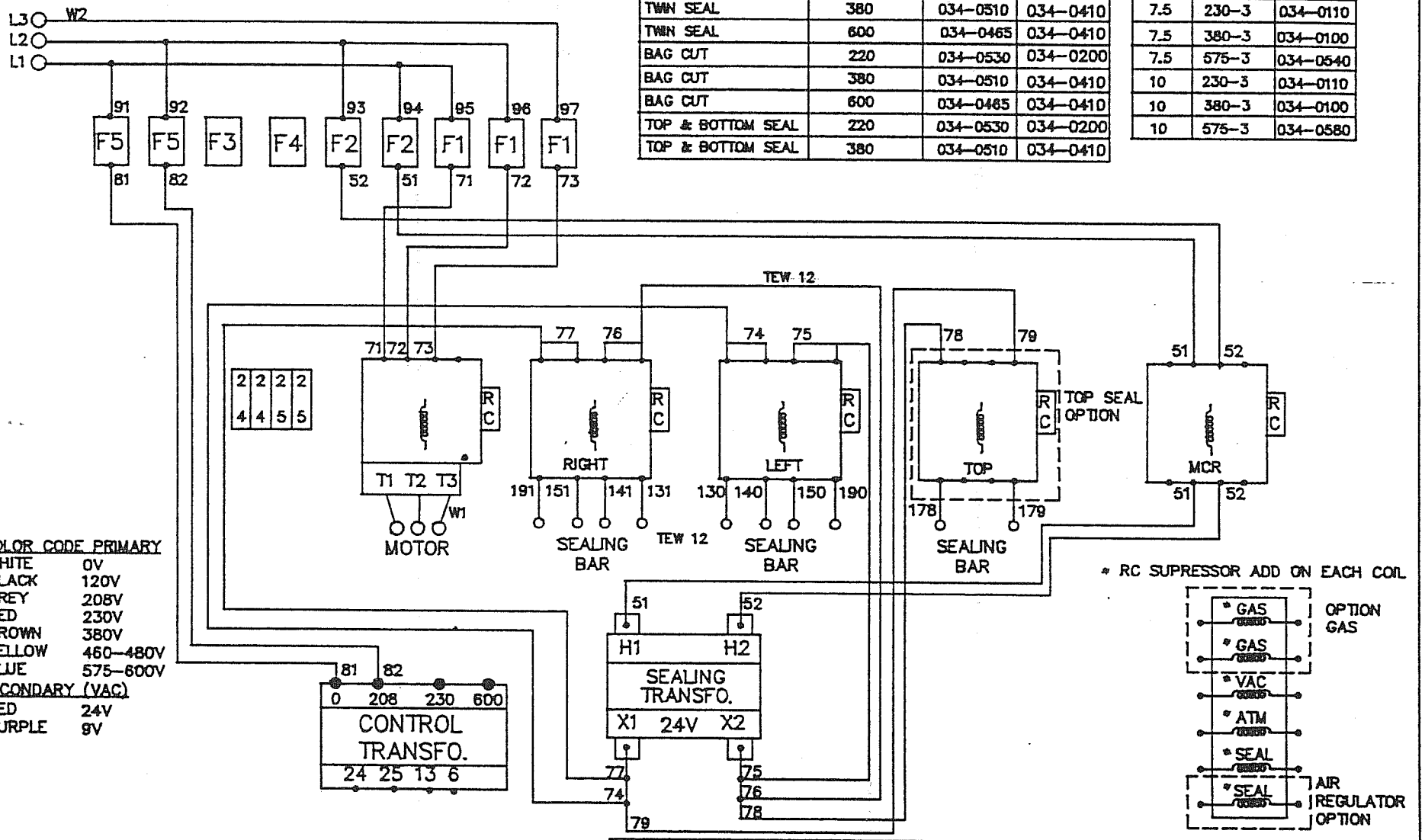
FOR PART NUMBERS FOR LETTERS (A) THRU (N) SEE FOLLOWING LIST

MACHINE	VACUUM DOUBLE CHAMBER	SIPROMAC
	LOW VOLTAGE WITH MC-40	ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
MAT:	DESS. D.L.	DATE 15 MAY 1998
	APP.	DATE
		NO. 016-0118

006-0037

OPTION	VOLTAGE	FUSE F2	FUSE F5
TWIN SEAL	220	034-0530	034-0200
TWIN SEAL	380	034-0510	034-0410
TWIN SEAL	600	034-0465	034-0410
BAG CUT	220	034-0530	034-0200
BAG CUT	380	034-0510	034-0410
BAG CUT	600	034-0465	034-0410
TOP & BOTTOM SEAL	220	034-0530	034-0200
TOP & BOTTOM SEAL	380	034-0510	034-0410

PUMP		
MOTOR	VOLT-PH.	FUSE F1
7.5	230-3	034-0110
7.5	380-3	034-0100
7.5	575-3	034-0540
10	230-3	034-0110
10	380-3	034-0100
10	575-3	034-0580



COLOR CODE PRIMARY

WHITE	0V
BLACK	120V
GREY	208V
RED	230V
BROWN	380V
YELLOW	460-480V
BLUE	575-600V

SECONDARY (VAC)

RED	24V
PURPLE	9V

WIRE LOCATION	W1		W2		W1		W2	
VOLTAGE	220		575		220		575	
PUMP	7.5				10			
SEAL OPTION	STAND.	TOP	STAND.	TOP	STAND.	TOP	STAND.	TOP
WIRE DIA.	10/4SJ	6/4SO	12/4SO	12/4SO	6/4SO	6/4SO	10/4SO	10/4SO

MACHINE: VACUUM 650A

PIECE: ELECT. WIRING HIGH VOLTAGE 3Ø

QT. ——— ECH. SCALE ——— NE PAS MESURER /N.T.S.

MAT:

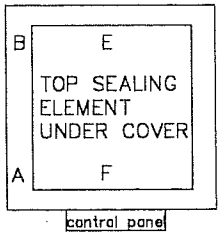
DESS. D. LETOURNEAU DATE 97-03-12

APP. DATE

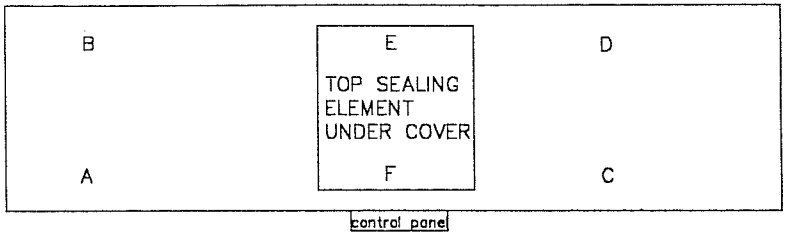
SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

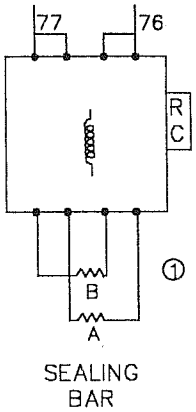
NO. 006-0037

SINGLE CHAMBER

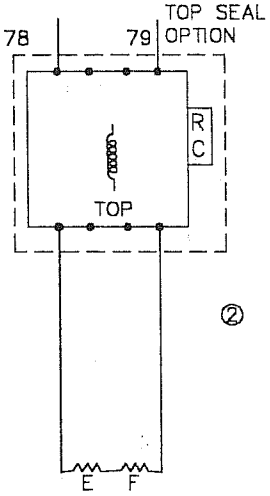


DOUBLE CHAMBER

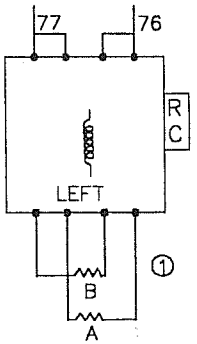




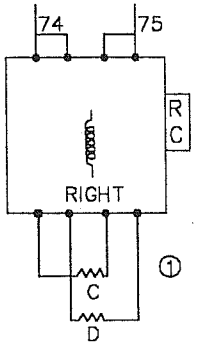
SEALING BAR



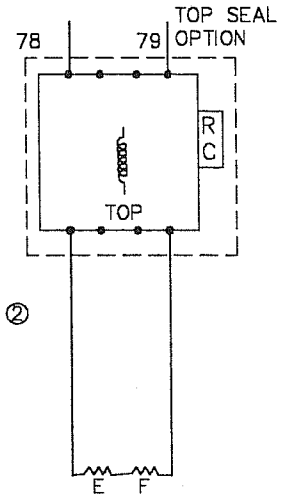
SEALING BAR



SEALING BAR



SEALING BAR



SEALING BAR

① WIRE TEW 12 AWG SIPROMAC # 030-0420

② WIRE CABTIRE 12/3 SJ SIPROMAC # 030-0120
CONNECTOR CD-13 SIPROMAC # 036-0409

MACHINE: ALL MODEL			SIPROMAC
PIECE: WIRING FOR SEALING BAR			ST-GERMAIN DE GRANTHAM, QUEBEC CANADA
QT. ———	ECH. SCALE ———	NE PAS MESURER /N.T.S.	
MAT:	DESS. ERIC J. T.P.	DATE 12 DEC 2000	NO. 006-0131
	APP.	DATE	

ELECTRICAL DRAWINGS PARTS LIST

A : VOLT	PHASE	PUMP HP	CONTACTOR	OVERLOAD
220	1	4	025-0050	025-0200
220	3	4	025-0030	025-0190
460	3	4	025-0010	025-0170
575	3	4	025-0010	025-0160
220	1	7.5	025-0070	025-0222
220	3	7.5	025-0040	025-0210
575	3	7.5	025-0010	025-0180
220	3	10	025-0060	025-0220
460	3	10	025-0030	025-0190
575	3	10	025-0020	025-0190

B,C & O: SEALING CONTACTOR: 025-0020

D: OPTIONAL GAZ SOLENOID VALVE: 106-0010

E: VACUUM SOLENOID VALVE: 106-0060

F: ATMOSPHERE SOLENOID VALVE: 106-0030
106-0050 WITH PUMP: 7.5 HP

G: BELLOWS SOLENOID VALVE: 106-0070

H, I, J: COVER SWITCH: 026-0590

K: SEALING TRANSFO.: 029-0172,029-0174

L: RELAY & BASE:

RELAY: 025-0600
BASE: 025-0610

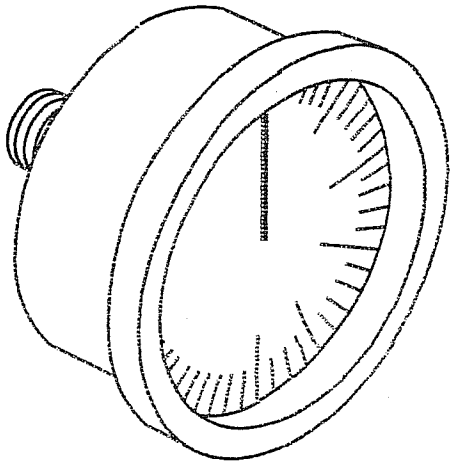
M: OPTIONAL TOP SEALING CONTACTOR: 025-0020

N: CONTROL TRANSFO.: 029-0007, 029-0008, 029-0009, 029-0250

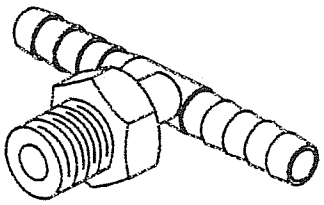
DAJG/86

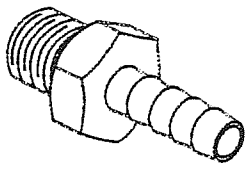
NOTES

SIPROMAC



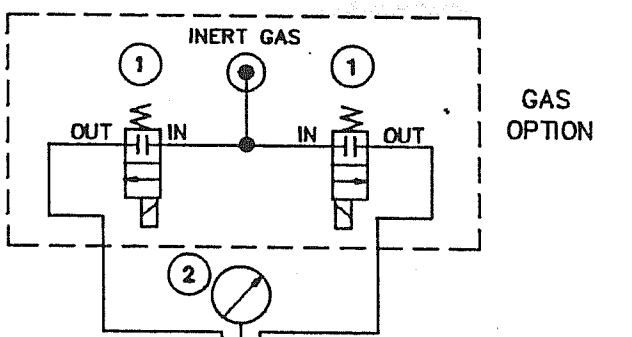
PNEUMATIC DRAWING



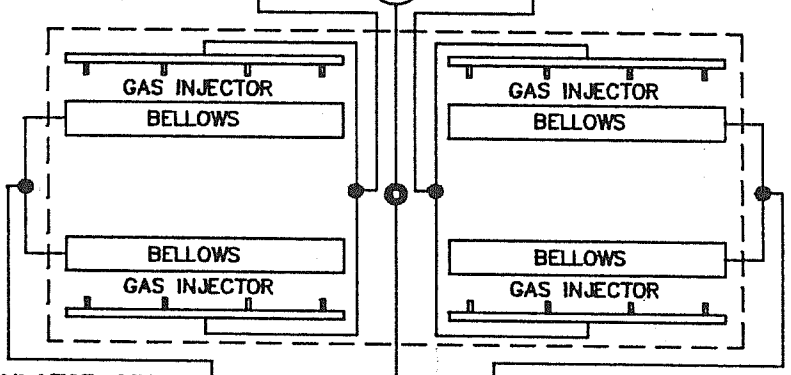


007-0019

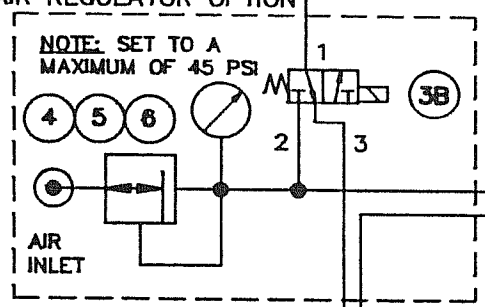
-NOTE:
-FOR GAS INJECTION KIT INSTALLATION SEE DRAWINGS #:
420A: #010-0016
600A: #010-0017
620A: #010-0018
650A: #010-0020

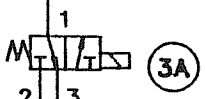


GAS OPTION

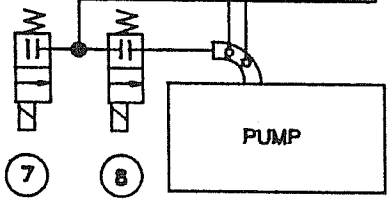


AIR REGULATOR OPTION



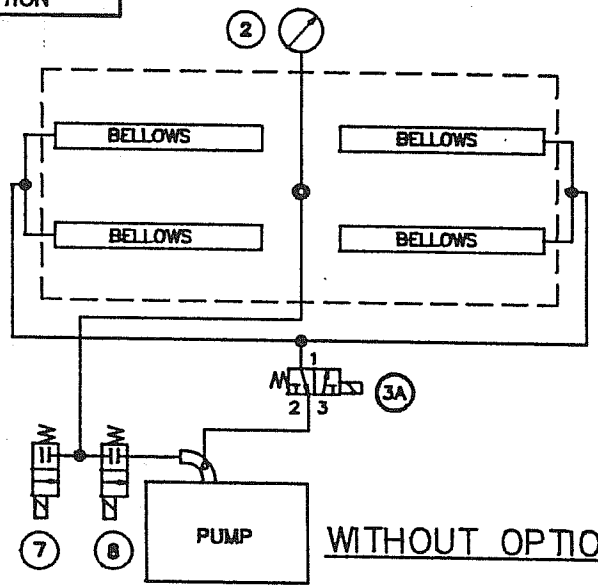


-NOTE:
-FOR AIR REGULATOR OPTION KIT INSTALLATION SEE DRAWINGS #: 010-0019 & 650A: #010-0027 (FOR EXISTING MACHINES)



WITH OPTIONS

ITEM	PART #	DESCRIPTION	QT.
1	106-0010	GAS VALVE	2*
2	114-0260	VACUUM GAUGE	1
3A	106-0070	BELLOWS VALVE	1
3B	106-0070	BELLOWS VALVE	1*
4	114-0147	PRESSURE REGULATOR	1*
5	114-0245	PRESSURE GAUGE	1*
6	114-0170	PRESSURE REGULATOR SUPPORT	1*
7	106-0030	ATMOSPHERE VALVE FOR 420A	1
	106-0030	ATMOSPHERE VALVE FOR 600A, 063M^3 AND 100 M^3	
	106-0050	ATMOSPHERE VALVE FOR 600A & 620A: 160 M^3 AND 250 M^3	
	106-0050	ATMOSPHERE VALVE FOR 650A & 700A	
8	106-0030	VACUUM VALVE FOR 420A	1
	106-0050	VACUUM VALVE FOR 600A & 620A	
	106-0060	VACUUM VALVE FOR 650A & 700A	
*: OPTION			



WITHOUT OPTION

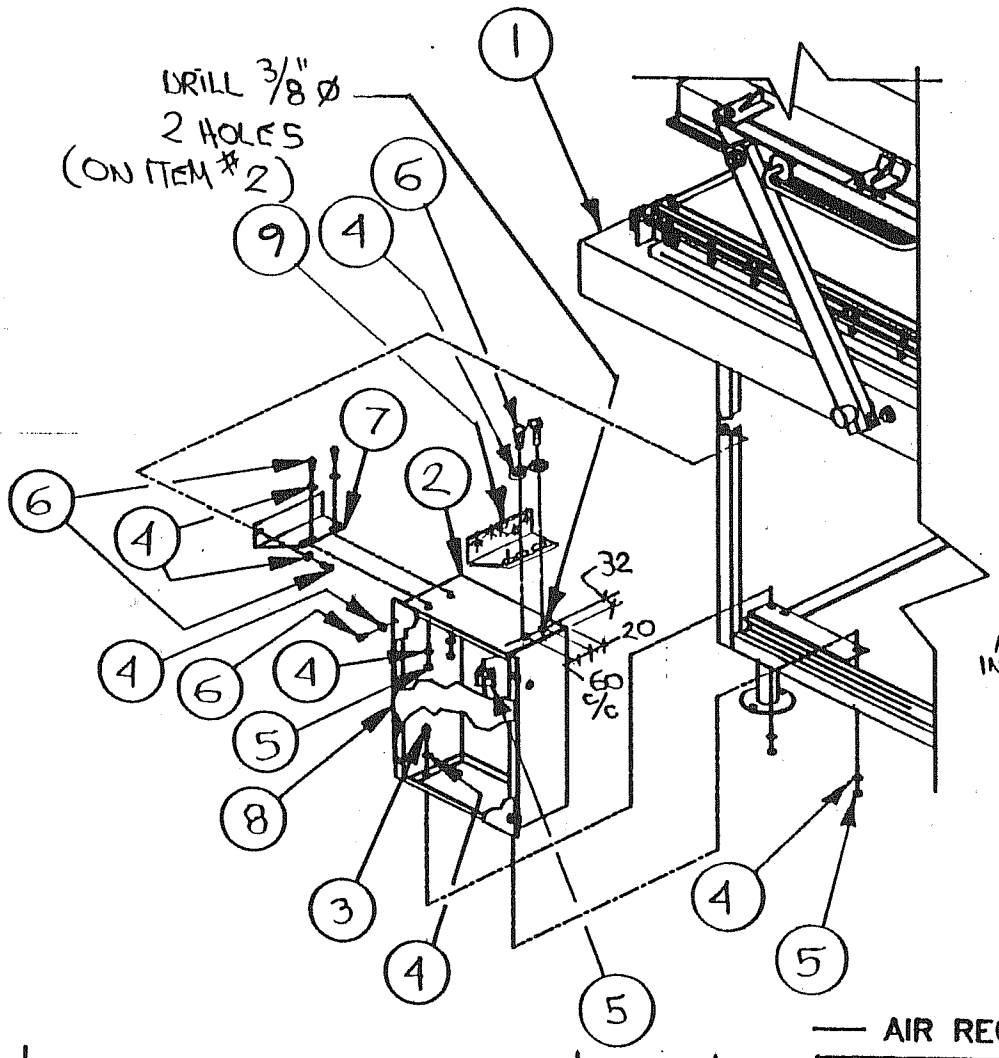
LET.	MODIFICATION	DATE	INT.
A	RE-DRAWN	97-03-11	M.L

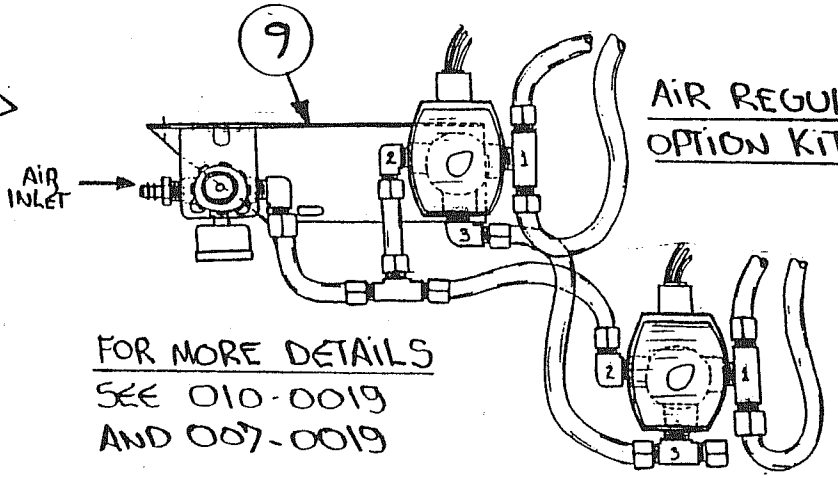
MACHINE: 420A,600A,620A & 650A
PART: PNEUMATIC
ITEM:
MAT:
CNC:
DWG BY: M.LAVIGNE
APP.
DATE: 97-03-11
DATE
N.T.S.
SCALE
QT. 1
NO. 007-0019

SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

010-0027

ITEM	PART #	DESCRIPTION	QT.
1	005-0353	MACHINE ASSEMBLY REAR VIEW	1
2	005-0374	ELECTRICAL BOX ASSEMBLY	1
3	051-0190	BOLT 1/4"-20 x 3/4" S/S	2
4	051-0740	WASHER 1/4" FLAT S/S	15
5	051-0580	NUT 1/4"-20 S/S	6
6	051-0180	BOLT 1/4"-20 x 1/2" S/S	9
7	001-1369	LEFT ELEC. BOX UPPER SUPPORT	1
8	004-0279	E-BOX COVER ASSEMBLY	1
9	009-0044	VALVE/REGULATOR SUPPORT	1





AIR REGULATOR OPTION KIT

FOR MORE DETAILS
SEE 010-0019
AND 007-0019

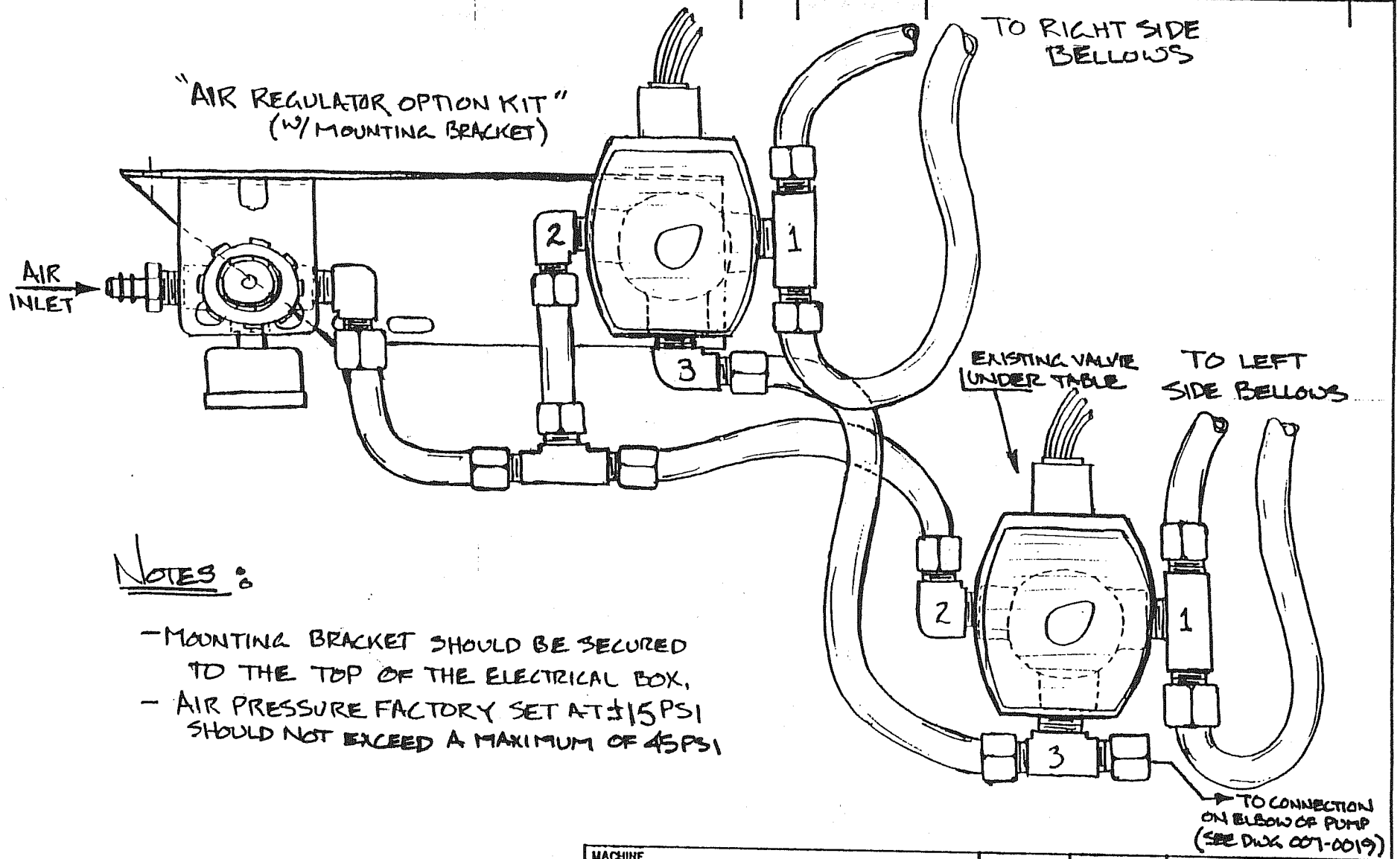
— AIR REGULATOR OPTION — (FOR EXISTING MACHINES)

MACHINE: 650A	METRIC TOLERANCE: 0 ± .5 / .0 ± .05 / .00 ± .005 / .000 ± .0005 / ANGLE ± 1°	INCH TOLERANCE: .0 ± .015" / .00 ± .005" / .000 ± .0005"	SIPROMAC		
PART: AIR REGULATOR OPTION KIT INSTALLATION		N.T.S.	ST-GERMAIN DE GRANTHAM, QUEBEC CANADA		
ITEM:	CNC:		SCALE:	QT. 1	
MAT:	DWG BY: DAVE A	DATE: 97-02-21	NO. 010-0027		
	APP.	DATE			

LET.		DATE	INT.
A	REDRAWN	97-02-21	
	MODIFICATION		

1010-0019

ITEM	# PIECE	DESCRIPTION	QT.



NOTES :

- MOUNTING BRACKET SHOULD BE SECURED TO THE TOP OF THE ELECTRICAL BOX.
- AIR PRESSURE FACTORY SET AT ±15PSI SHOULD NOT EXCEED A MAXIMUM OF 45PSI

LET.	MODIFICATION	DATE	INT.

MACHINE: 420A, 600A, 620A & 650A.
PIECE: AIR REGULATOR OPTION KIT INSTALLATION
QT.: 1
ECH. SCALE:
MAT:
DESS.: DAVE A
APP.:
DATE: 97-02-21
DATE:

METRIC TOLERANCE: 0 ± .5 / .0 ± .05 / .00 ± .005 / .000 ± .0005 / ANGLE ± 1°
INCH TOLERANCE: .0 ± .015" / .00 ± .005" / .000 ± .0005"
N.T.S.

SIPROMAC
ST-GERMAIN DE GRANTHAM, QUEBEC CANADA

NO. 010-0019

United States Department of Agriculture

Food Safety and Inspection Service

Washington, D.C. 20250

May 14, 1992

Sipromac, Inc.

The following equipment is acceptable for use in federally inspected meat and poultry plants:

EQUIPMENT: Vacuum Packaging Machine, Models: Sipromac 650A, Sipromac 600A, Sipromac 550A, and Sipromac 420A

This acceptance is with the understanding that all future equipment designated by a similar model number will be of the same design and material as those for which this letter is written. Once this equipment is published in our "Accepted Meat and Poultry Equipment" booklet, this letter becomes invalid and can no longer be used as an authorization for installation of equipment in plants.

This acceptance does not imply compliance with Department of Labor Occupational Safety and Health Standards, nor should it be considered as an approval of processing methods. Any departure from established procedures must be cleared with the Slaughter Inspection Standards and Procedures Division or the Processed Products Inspection Division.

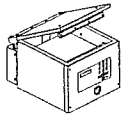
Sincerely,

Robert E. Owens
Industrial Specialist
Equipment Branch
Facilities, Equipment and Sanitation Division
Science and Technology

NOTES:

SIPROMAC

NOTES



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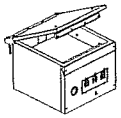

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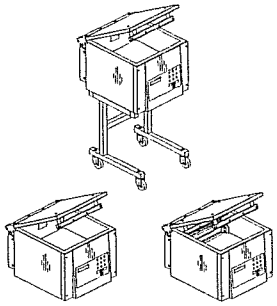

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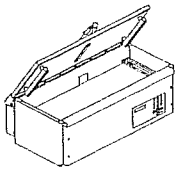

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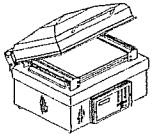

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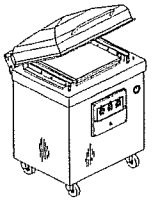

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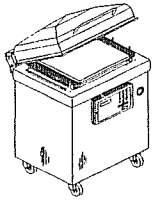

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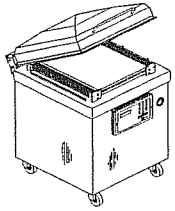

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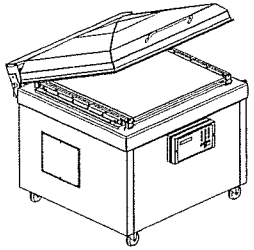
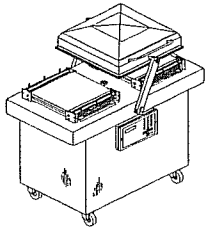


580A

SIPROMAC

VACUUM PACKAGING MACHINES



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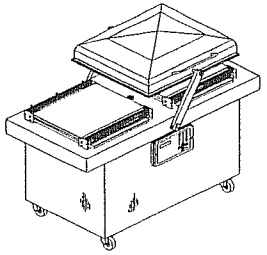

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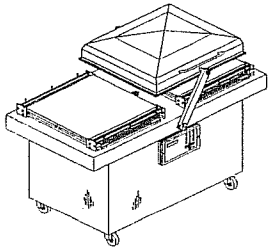

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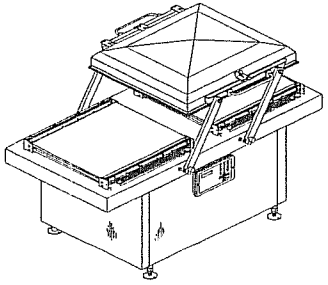

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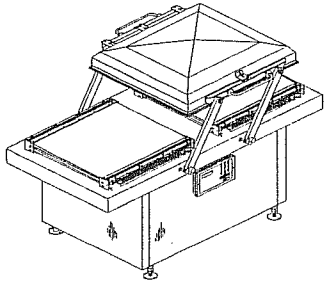

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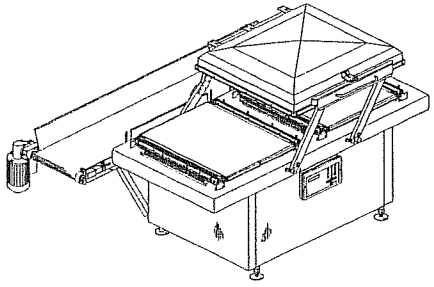

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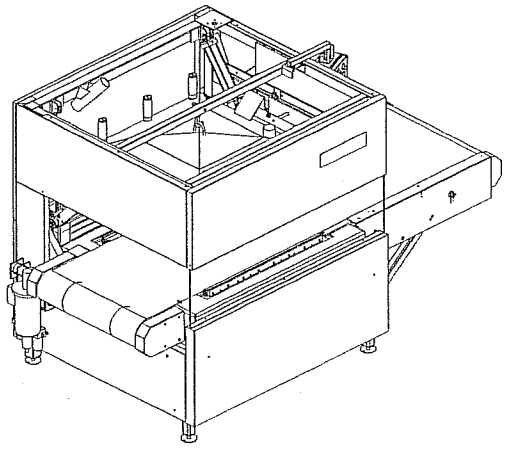

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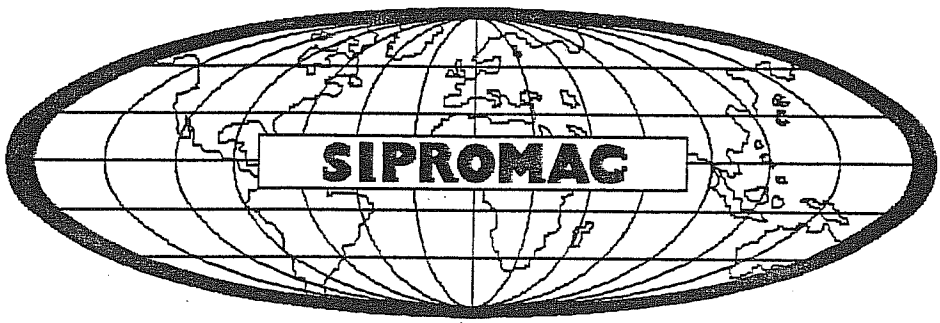

SIPROMAG

MANUEL D'UTILISATEUR

MICROPROCESSUR MC-40 AVEC DÉTECTEUR DE VIDE

EMBALLEUSE SOUS VIDE

TABLE DES MATIÈRES

EMBALLEUSES SOUS VIDE
INSTRUCTIONS D'OPÉRATIONS

TABLE DES MATIÈRES

SIPROMAC INC.
EMBALLEUSES SOUS VIDE

1. MISE EN PLACE DE LA MACHINE:

Avant de choisir le site d'installation de votre machine, veuillez considérer que vous aurez besoin d'espace pour les produits emballés et non-emballés à part de l'espace occupé par la machine elle-même.

Bien vouloir vous rappelez que vous aurez besoin d'un sol bien au niveau pour votre installation. Spécialement avec les modèles mobiles, le poids de la pompe peut gauchir la machine et le le couvercle ne fermera plus correctement.

Avant de commencer à travailler, vérifier l'huile de la pompe pour voir si elle est en quantité suffisante. Bien vouloir ne jamais utiliser une huile autre que celle recommandée par le fabricant. Ne pas excéder la quantité indiquée quand vous ajoutez ou faites le changement d'huile et faites votre vérification hebdomadairement.

En raison de la viscosité de l'huile, la machine sera plus difficile à démarrer à basses températures. Ainsi donc la pompe doit être placée dans un endroit où la température est d'au moins 50°F (+10°C). D'autre part, l'air doit circuler librement aux alentours de la pompe pour permettre le refroidissement dans les cas où la température des opérations atteindrait 160°F (70°C) ou la température maximale permise.

2. CONNECTION ÉLECTRIQUE:

Les connections électriques doivent se faire par du personnel qualifié. La personne désignée doit s'assurer que les entrées électriques correspondent au voltage et à l'ampérage approprié de la machine.

Un schéma électrique accompagne chacune de nos machines.

Une étape importante dans le branchement de la machine est de s'assurer que le moteur de la pompe tourne dans une rotation appropriée.

> Attention: Le moteur de la pompe ne devrait pas tourner plus de 3 ou 4 secondes dans une mauvaise rotation car il en résultera des dommages sérieux. La rotation est indiquée par une flèche dur le moteur de la pompe.

3. OPÉRATION:

3.1 Principes de travail:

Un empaquetage sous vide est un cycle composé de 3 étapes. Premièrement le vide est fait et l'air est complètement enlevé de la chambre et du sac contenant le produit. (Voir figure 1). Ensuite c'est possible d'injecter du gaz neutre par les conduits si le produit est très délicat. Finalement, un mécanisme pousse la barre de scellage sur le support de caoutchouc pour sceller le sac

Pour obtenir de beaux empaquetages, les produits et les sacs doivent être de taille proportionnelles. L'ouverture du sac ne devrait jamais excéder 2" (50cm) au delà des barres de scellage. Le produit doit être centré en hauteur par rapport aux barres de scellage en ajustant les écarteurs qui vous sont fournis.

Pour obtenir un bon scellage, assurez-vous qu'il n'y a pas de résidu de graisse qui reste entre les côtés intérieurs des sacs où le scellage doit être fait.

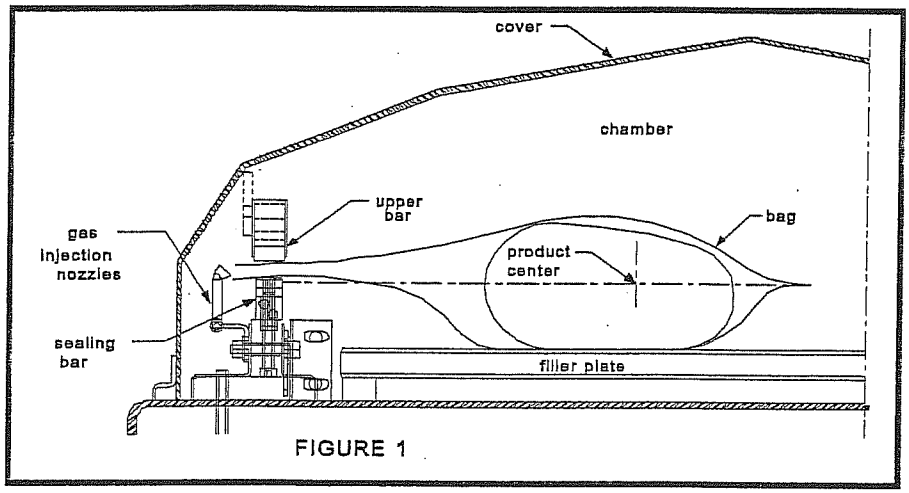


FIGURE 1

3.2 Empaquetage Spécial:

3.2.1 Injection de Gaz (option):

Il y a une pression atmosphérique de 14 lbs / pouce carré (= 1 kg / cm carré) sur les produits quand le vide demandé est atteint. Les produits qui peuvent être endommagés par une haute pression doivent être empaquetés avec un vide partiel et la pression doit être contrebalancée en injectant du gaz dans le sac (nitrogène ou dioxyde de carbone) avant le scellement et après avoir atteint le vide.

Pour l'injection de gaz, les sacs sont placés sur les barres de scellage, l'ouverture placée au dessus des conduits de gaz qui sont montés le long des barres de scellage. Après que le vide soit atteint, la valve du vide se ferme et la valve du gaz s'ouvre. Le pourcentage de gaz peut être ajusté par le menu du programme.

Le réservoir de gaz et la valve de pression qui est rattachée au réservoir ne sont pas fournis par Sipromac. La pression pour le régulateur de gaz devrait être ajustée approximativement à 5 lbs/pouce carré (1/3 Kg/cm carré). Chaque machine a un adapteur pour la connexion de gaz quand l'option de l'injection de gaz est commandée.

3.2.2 Scellage Haut et Bas (optionnel):

Pour le scellage des sacs en aluminium comme pour le café il est impératif d'avoir une barre de scellage en haut et en bas.

3.2.3 Coupe sac électrique: (optionnel):

Cette option est utilisée pour obtenir un paquet dont l'excédent de film au niveau du scellage doit être coupée très près de la ligne de scellage. (cette option ne peut pas être utilisée avec le scellage Haut et Bas)

3.3 Les opérations de l'empaquetage sous vide:

Note: Reportez-vous aux menus structure de la page 8 et aux détails du panneau de contrôle sur la page 9

3.3.1 Bases:

Utilisez la touche "POWER" pour initier le bouton ON/OFF sur votre machine sous vide. Quand votre unité sera en fonction le dernier programme exécuté apparaîtra sur l'écran à cristaux liquides.

Utilisez la touche "ESC" pour passer du menu programme au menu fonctions et du menu des fonctions au menu des programmes.

Dans le menu des fonctions, utilisez la touche "SELECT" pour sélectionner une fonction et la touche "ENTER" pour exécuter la sélection.

Dans le menu des programmes, utilisez la touche "SELECT" pour sélectionner un programme et la touche "Enter" pour accéder ou modifier la sélection.

Dans les programmes du sous menu, utilisez la touche "ENTER" pour voir défiler les paramètres et lorsque ces derniers clignotent pour indiquer ils sont dans le mode d'acquisition. Quand la séquence de tous les paramètres se sont affichés, on revient automatiquement au début de la liste.

Dans les programmes du sous menu, utilisez la touche "ESC" pour revenir au menu des programmes. Pressez n'importe quelle touche pour effacer les messages d'erreur qui peuvent s'afficher sur l'écran à cristaux liquide.

3.3.2 Menu des fonctions:

3.3.2.1 Créer un programme:

Quand vous exécuter la fonction "create a program", le programme sous menu est atteint en commençant par l'identification. L'identification initiale "PxxNO NAME" est donné au programme et tous les paramètres sont établis à zéro; le numéro du programme est alloué automatiquement.

3.3.2.2 Supprimer un programme:

En exécutant la fonction de "delete a program", vous avez accès au menu des programmes et le numéro du premier programme en mémoire clignote pour indiquer le mode de suppression. Utilisez la touche "SELECT" pour sélectionner un programme et la touche "ENTER" pour avoir accès et confirmer la suppression de la sélection. Utilisez la touche "ESC" pour annuler une suppression et quitter la fonction. Quand vous quittez la fonction, le nombre des programmes actuels sur l'écran à cristaux liquides cesse de clignoter.

3.3.2.3 Choisir le mode d'opération:

Quand vous exécutez la fonction "Select Operating Mode", laquelle est disponible seulement pour les unités automatiques, la sélection en cours clignote pour vous indiquez le mode. Utilisez la touche "SELECT" pour parcourir les modes d'opération, lesquels sont automatiques, semi-automatiques et manuels. Le mode

d'opération sera validé et exécuté automatiquement. Utilisez la touche "ESC" ou "ENTER" pour quitter la function et retourner au menu des programmes.

3.3.3 Menu des Programmes:

3.3.3.1 Identification des Programmes:

Pour un programme sélectionné, choisissez l'identification en utilisant le panneau de contrôle numérique avec la chartre des caractères et pressez sur la touche numérique jusqu'à ce que le caractère soit sélectionné (4 x pour la valeur numérique). Utilisez la touche "ENTER" pour valider le caractère ainsi que la chaîne de caractères jusqu'à la fin (la nouvelle chaîne de caractères clignote). Vous pouvez utilisez la touche "ESC" pour revenir en arrière dans le cas où vous vous êtes trompé et que vous voulez effacer le caractère.

Example: EXAMPLE 1 →	Touche 2, 2, ENTER	→ E
(9 caractères)	Touche 8, 8, 8, ENTER	→ X
	Touche 1, ENTER	→ A
	Touche 5, ENTER	→ M
	Touche 6, ENTER	→ P
	Touche 4, 4, 4, ENTER	→ L
	Touche 2, 2, ENTER	→ E
	Touche 9, 9, 9, ENTER	→ espace
	Touche 1, 1, 1, 1, ENTER	→ 1
	Touche ENTER pour valider la chaîne de caractères	

3.3.3.2 L'ajustement du niveau de Vide:

Pour un programme sélectionné, ajustez le niveau de vide avec les valeurs; le point décimal est automatiquement inséré suivant la deuxième entrée digitale et la validation est automatiquement exécutée après la troisième entrée digitale (La nouvelle valeur du niveau du vide clignote). Le niveau de vide est arrondi à la demie la plus près de la valeur. En cours de traitement, utilisez la touche "ENTER" pour valider la valeur du niveau de vide et la touche "ESC" pour revenir en arrière et changer la valeur du niveau de vide (La valeur du niveau de vide la plus ancienne clignotera à ce moment). Ajustez le niveau du vide à zéro pour pouvoir contourner le capteur de vide et procédez en réglant seulement le " Temps de vide Plus" (Vacuum plus time).

Exemples:	90.0%	→Touches 9, 0, 0 ou 9, 0, ENTER ou Touches 9, 0, 1 ou 9, 0, 2 or 9, 0, 3 ou 9, 0, 4
	97.5%	→Touches 9, 7, 5 ou Touches 9, 7, 6 ou 9, 0, 7 or 9, 0, 8 ou 9, 0, 9
	0.0%	→Touches 0, 0, 0 ou 0, ENTER

3.3.3.3 Ajustement du Temps de Vide "Plus":

Pour un programme sélectionné, réglez le "temps de vide plus" en secondes; la validation est automatiquement exécutée après la deuxième entrée digitale (La nouvelle valeur du "temps de vide plus" clignotera à ce moment). En cours de traitement, utilisez la touche "ENTER" pour valider la nouvelle valeur du "temps de vide plus" et la touche "ESC" pour revenir et recommencer avec de nouvelles

valeurs (la valeur la plus ancienne du "temps de vacuum plus" clignotera).

Exemples: 1s ➔Touche 0, 1 or 1, ENTER
15s ➔Touche 1, 5

3.3.3.4 Ajustement de l'injection de gaz

Pour sélectionner un programme placer le niveau d'injection de gaz en suivant la même procédure que pour le niveau de vide; L'ajustement pour le gaz le plus haut devrait être de 10% au-dessous du niveau de l'ajustement de vide.

3.3.3.5 Ajustement du cachetage:

Pour sélectionner un programme le temps de cachetage, en commençant par les secondes; le point décimale est automatiquement insérée après la première entrée de chiffre et la validation est automatiquement effectuée après la troisième entrée de chiffre (le nouveau temps de cachetage clignote). Le temps de cachetage est arrondi à la moitié la plus proche du cent. À un milieu l'entrée des données, utiliser la clé "ENTER" pour valider l'heure du cachetage et la clé " ESC " pour revenir en arrière et reprogrammer le temps cachetage avec de nouvelles données (le vieux temps de cachetage clignote).

Examples: 4.50s ➔ clés 4, 5, 0 or 4, 5, ENTER or
clés 4, 5, 1 or 4, 5, 2 or 4, 5, 3 or 4, 5, 4
2.35s ➔ clés 2, 3, 5 or
clés 2, 3, 6 or 2, 3, 7 or 2, 3, 8 or 2, 3, 9
0.00s ➔ clés 0, 0, 0 or 0, ENTER

3.3.4 Exécution de cycle de vide :

Pour les unités manuels ainsi que les unités automatiques faire la mise en marche manuelle, fermer le couvercle afin de lancer un cycle de vide. Pour l'unité automatique faire mise en marche semi-automatique ou automatique, utilisez le bouton "ARRÊT / DÉBUT" pour lancer ou interrompre un cycle de vide. Le programme sélectionné peut être lancé seulement dans le programme du menu, au moment où aucune modification n'est nécessité, et l'accès des autres programmes et des fonctions ne sont pas requis. Pendant l'exécution du cycle le statut d'opération est séquentiellement affiché sur l'écran à cristaux liquides, excepté pour les paramètres établis à zéro, qui ne sont pas montrés:

- niveau de vide de la chambre pendant la séquence,
- vide additionné du temps pendant le vide plus la séquence,
- niveau de vide de la chambre pendant la séquence d'injection de gaz,
- statut de temps de cachetage pendant la séquence de cachetage,
- niveau de vide de la chambre pendant La séquence d'atmosphère .7

Pendant l'exécution du cycle, utilisé la clef "1" pour interrompre la séquence de vide et pour exécuter la séquence suivante, sois l'injection du gaz ou le cachetage, suivi de la clé

"ENTER" afin d'accéder et modifier le programme; les paramètres deviennent valides seulement pour les cycles suivants de vide.

3.3.5 System monitor:

Pour accéder le menu des diagnostics, monter la puissance de la machine d'emballage sous vide tout en maintenant le bouton "'ESC" enfoncé. Utilisez la clé "SELECT" pour choisir la fonction du système du moniteur et "ENTER" pour accéder et visualiser les paramètres surveillés. Employez la clé "SELECT" pour changer la révision de logiciel, la quantité d'heures de travail faites et de la quantité de cycles complets exécutés depuis la première initialisation.

-MENUS STRUCTURE-

- Functions menu:

  "F1 CREATE A PRGM"
  "F2 DELETE A PRGM"
  "F3 SELECT OPMODE" (automatic units only)

- Programs menu:

  "Pxx NAME"

  Program submenu:

	"VACUUM: xx.x%"	(10.0% - 99.5%)
	"VACUUM PLUS: xxs"	(0s - 99s)
(units with gas option)	"GAS FLUSH: xx.x%"	(0.0% - 10% below the vacuum level)
	"SEAL TIME: x.xxs"	(0.00s - maximum unit allocated setting)
	"Pxx NAME"	(12 characters)

- Diagnostics menu (keys "ESC" & "POWER" for access):

  "DIAGNOSTICS MENU" (access code required)

  "D1 INPUTS TEST"

  "D2 OUTPUTS TEST"

  "D3 MODEL SELECT"

  "D4 GAS OPTION"

  "D5 SEALING TIME"

  "D6 COOLING TIME"

  "D7 LOADING TIME" (automatic units only)

  "D8 UNLOADNG TIME" (automatic units only)

  "SYSTEM MONITOR" (no access code required)

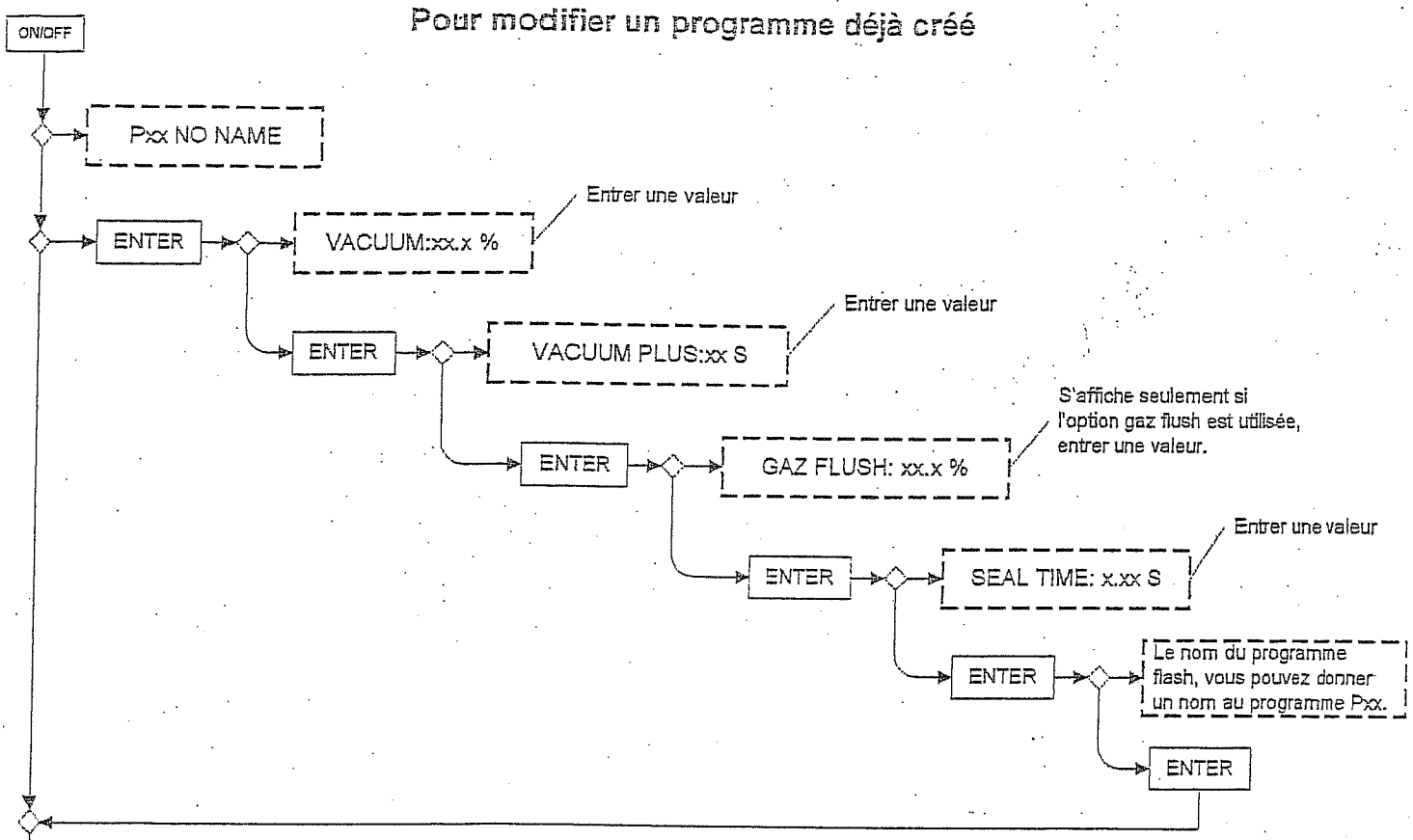
  "SOFTWARE: R x.xx"

  "WORK HRS: xxxxx"

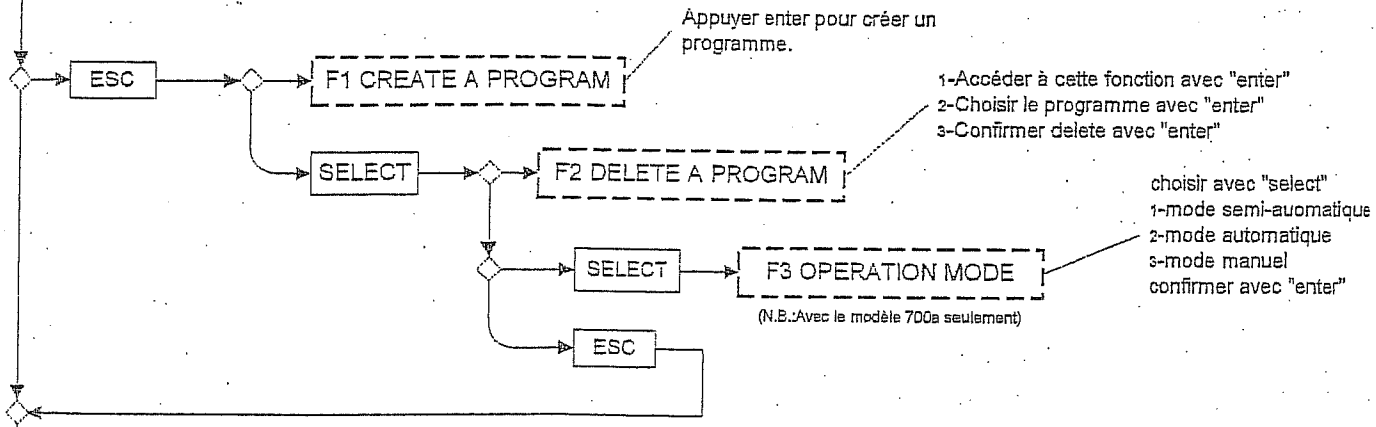
  "CYCLES: xxxxxxx"

PROGRAMMATION MC-40

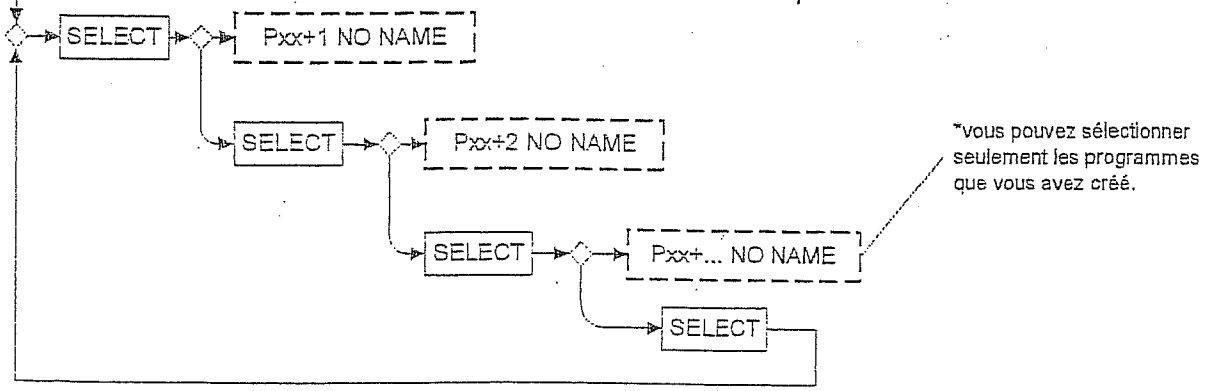
Pour modifier un programme déjà créé



Pour créer un programme

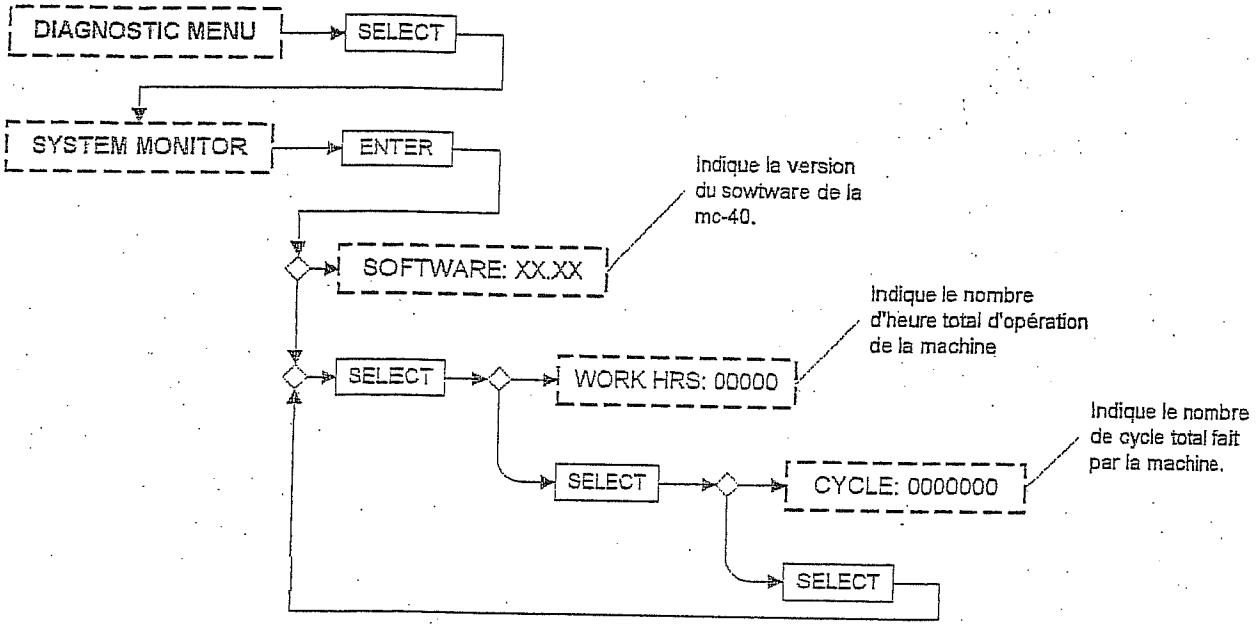


Pour sélectionner un programme créé



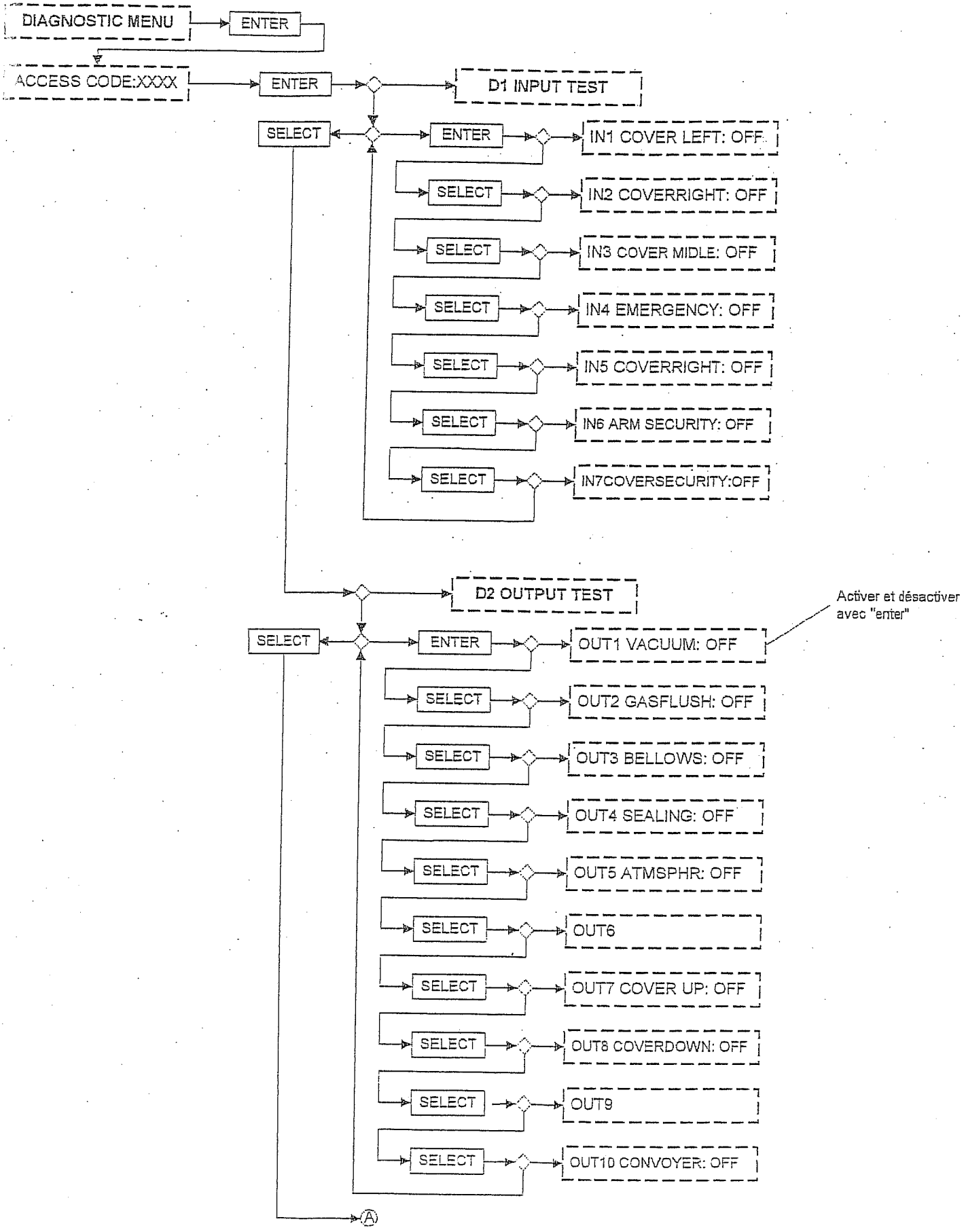
SYSTEM MONITOR

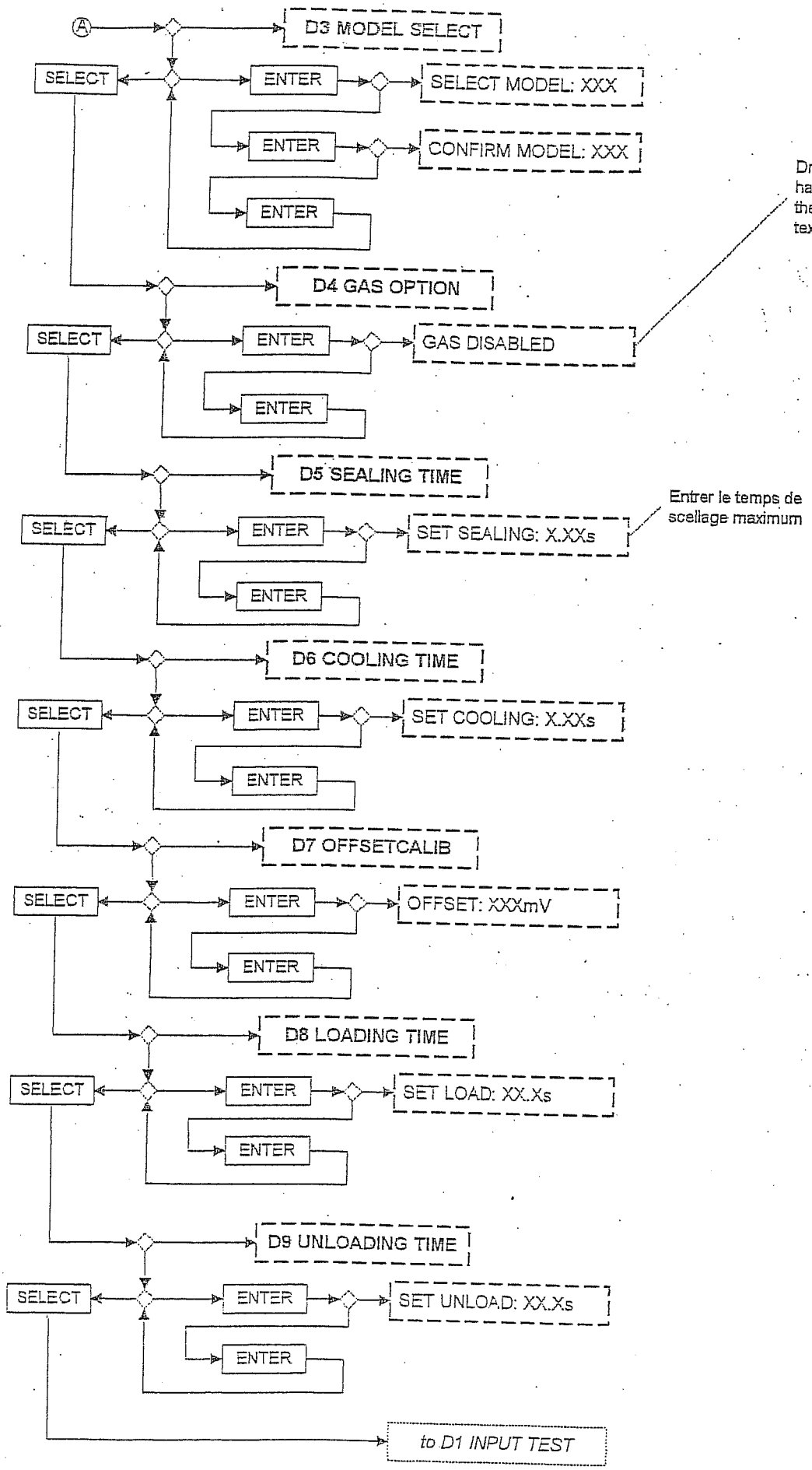
Pour acceder au menu "system monitor", mettre la machine à off, tenir la touche "esc", appuyer et relacher la touche "on/off" et finalement relacher la touche "esc". L`affichage indique DIAGNOSTIC MENU, appuyer sur select pour accéder au SYSTEM MONITOR.



DIAGNOSTIC MENU

Pour acceder au "DIAGNOSTIC MENU", mettre la machine à off, tenir la touche "esc", appuyer et relacher la touche "on/off" et finalement relacher la touche "esc". L'affichage indique DIAGNOSTIC MENU, appuyer sur enter pour y accéder.




Ⓐ
D3 MODEL SELECT
SELECT
ENTER
SELECT MODEL: XXX
ENTER
CONFIRM MODEL: XXX
ENTER
D4 GAS OPTION
SELECT
ENTER
GAS DISABLED
ENTER
D5 SEALING TIME
SELECT
ENTER
SET SEALING: X.XXs
ENTER
D6 COOLING TIME
SELECT
ENTER
SET COOLING: X.XXs
ENTER
D7 OFFSETCALIB
SELECT
ENTER
OFFSET: XXXmV
ENTER
D8 LOADING TIME
SELECT
ENTER
SET LOAD: XX.Xs
ENTER
D9 UNLOADING TIME
SELECT
ENTER
SET UNLOAD: XX.Xs
ENTER
to D1 INPUT TEST
Drag the side handles to change the width of the text block.
Entrer le temps de scellage maximum